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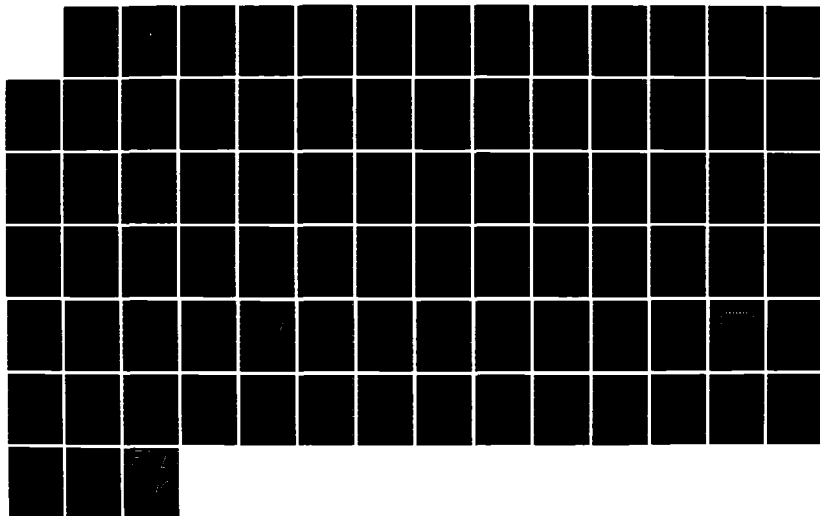
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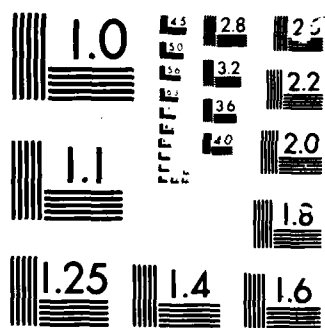
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THESIS

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TESTING METHODS  
FOR INTEGRATED CIRCUIT CHIPS

by

Zafer Betoner

21 March 1986

Thesis Advisor:

M. L. Cotton

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Testing Methods  
For Integrated Circuit Chips

by

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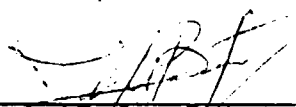
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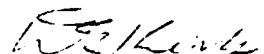
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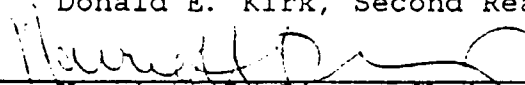
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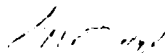
  
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## ABSTRACT

Provision for the functional testing of fabricated VLSI chips frequently involves as much design effort as the original chip design itself. Often the hardware requirements for testing involve a large expense.

This research investigates the logical and functional requirements for chip testing. Available approaches are examined and their capabilities noted. Methods of communication between the test controller and the device under test are examined as well as logical structure of the test controller.

Two candidate approaches are selected for comparison. (1) A standard general-purpose processor with standard bus interface serves as the test controller and (2) a custom VLSI test controller interfacing directly to the device under test. As a result, a test system architecture is proposed.

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## I. INTRODUCTION

The continued and rapid increase in the performance and complexity of VLSI technology creates a challenge for the design, development and test of integrated circuits.

This motivation attracts attention to the structured design methods which make possible the implementation of VLSI systems with little previous experience. There are design validation tools available, e.g., layout languages, design rule checkers, circuit extractors and simulators. These tools provide a simple way to simulate and verify the design. On the other hand, designers have no widespread and easy to use tools for debugging and testing when they receive their chip. If prototype chips are to be used in systems it is essential to verify that the designed chip performs the intended function successfully. So the problem of developing a methodology to test the circuits of VLSI technology efficiently needs to be addressed.

Properly defined test vectors are applied to the inputs of the device under test and outputs can be compared to a stored correct response. The simplest testing idea is shown in Figure 1.1. In general,  $2^n$  test vectors are required in this case.

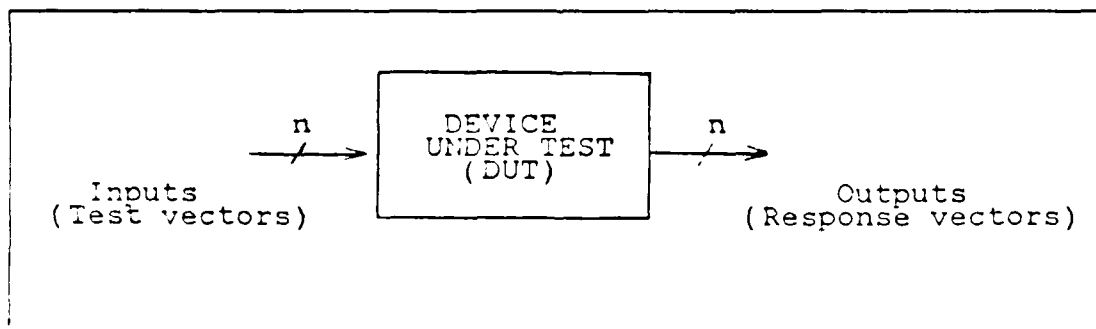


Figure 1.1 Combinational Circuit.

The test vectors should be carefully selected if they are to supply relevant information about a chip [Ref. 1]. A sequential circuit, as in Figure 1.2, is more difficult to test, since the output of a sequential circuit network depends not only on the present inputs but also on the internal state of the circuit. The number of test vectors required for this case are  $2^{n+m}$ .

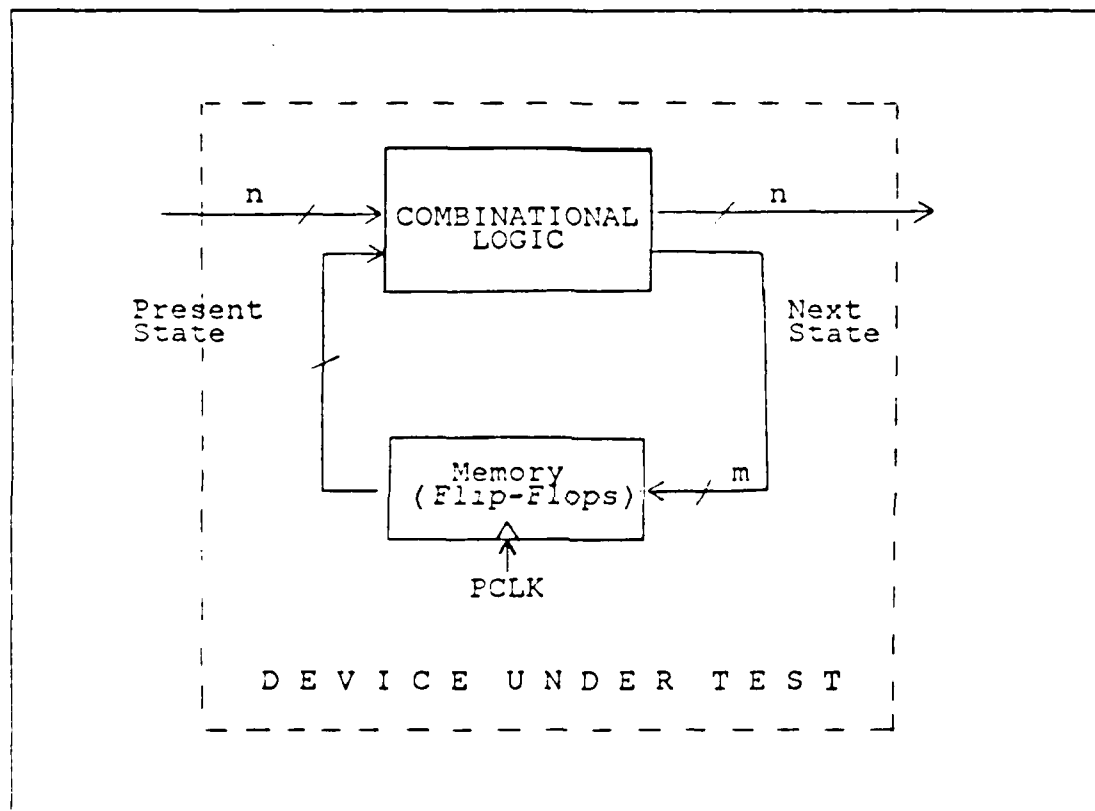


Figure 1.2 Sequential Circuit.

It is a fact that that test vectors may be generated and results may be compared in a computer aided environment.

The rest of the chapters investigate testing methods and systems for integrated circuit chips. In Chapter Two the most popular and available approaches are examined. Their

advantages and disadvantages are noted. The main purpose of this study is to set basic guidelines and decide on a useful test strategy for an academic environment. Chapter Three introduces the requirement of testing and explains why a functional test strategy is chosen. In Chapter Four, two candidate approaches for a tester are examined and results are derived. The first one is a general purpose processor with standard bus interface and serves as the test controller. The second is a custom VLSI test controller interfacing directly to the device under test. Chapter Five proposes a test system architecture which includes all of the considerations derived before. Conclusions and recommendations are given in the last chapter.

## II. CONCEPT OF TESTING VLSI CIRCUIT CHIPS

### A. DESIGN VERIFICATION

Design Verification is a test process which is done during the design. Following are two definitions of Design Verification:

1. " Design Verification Testing involves the simulation of a set of input nodes with a known set of input test vectors and capture of vectors from a set of output nodes to verify the logical integrity of a design." [Ref. 2]
2. " Design Verification (is the process of) establishing that the logical design of a given digital network does not contain any timing problems which could prevent it from performing the intended function under certain conditions." [Ref. 3]

Design Verification is performed to ensure that all circuit characteristics are compatible, that required specifications can be achieved, and to ensure that no major design flaws remain. Simulation is employed to check for the adequacy of the design. In general this may be accomplished with assistance from a design automation system [Ref. 4]. It must be noticed that verification techniques and tools are used during the design phase. The test capability we wish to develop, which is different than design verification testing, is to verify that the designed chip accomplishes its intended function successfully.

### B. TEST GENERATION AND VERIFICATION

Test generation is the process of searching for a sequence of input test vectors which verify correct behavior of the circuit. Test verification is concerned with finding measures of effectiveness of a given set of test vectors.



Test generation is complicated by flip-flops, circuit initialization needs, asynchronous circuits, indeterminate states and non-functional inputs [Ref. 5]. On the other hand, a complete set of test vectors does not guarantee an adequate test. All of these considerations should be addressed when developing a test strategy and a test plan.

As stated in [Ref. 6], test generation must consist of three main activities:

1. Selecting a good descriptive model, at a suitable level, for the system under consideration. Such a model should reflect the exact behavior of the system in all its possible modes of operation.
2. Developing a fault model to define the types of faults that will be considered during test generation. In selecting a fault model, the percentage of possible faults covered by the model should be maximized, and the test costs associated with the use of the model should be minimized. A good fault model is usually found as a result of a trade-off between them.
3. Generating tests to detect all the faults in the fault model. This part of test generation is the essential piece of the whole test process. Generating a test sequence to detect a certain fault in a digital circuit usually involves two problems. First, the fault must be excited; i.e., a certain test sequence must be applied that will force a faulty value to appear at the fault location if the fault exists. Second, the test must be made sensitive to the fault; i.e., the effect of the fault must propagate through the network to an observable output.

It is also important to locate the fault as well as detecting it. The test strategy is going to be changed, depending on whether it is desired simply to detect the fault or both to detect and locate the fault.

The challenge of fault simulation and test verification problems has received a lot of attention, and the task of test generation has been partially overlooked. The use of a random-number pattern generator and generation of a test which detects a single failure shows the degree of underestimation of the importance of the test-generation process. The manual generation of test patterns is a difficult, time-consuming job even for moderate size circuits. The task of

fault simulation and test verification is a bookkeeping, grading, direction-giving, and fault-dictionary-building task. [Ref. 7]

Fault simulation has been the goal of test generation, yielding a quantitative measure of test effectiveness. In other words, a test sequence is considered good if it can detect a high percentage of the possible device under test faults. It goes beyond logic and timing verification and is a more complex process. Fault simulation must predict how a circuit will, or can, fail and if this failure happens, the test program must be comprehensive enough to find it. [Ref. 5]

There are lots of algorithms, models and simulations based on fault detection. Let us review them briefly.

#### 1. Fault Simulation and Fault Models

Extensive studies have been made of the failures occurring in integrated circuits. These are examined in [Ref. 9]. This report states that failures have two major sources: defects in the manufacturing process, and component wearout. The frequency of occurrence and relative importance of the various faults depends on the circuit type (TTL, ECL, NMOS, CMOS, etc.) and the manufacturing technology used. Table 1 from [Ref. 9] summarizes the most common IC faults.

Given any physical fault mechanism in a circuit, it is possible, at least in principle, to determine its effect on the logical behavior of the circuit. As stated in [Ref. 9], there are several advantages to using logical fault models instead of physical fault models:

1. Once we have a logical fault model that adequately reflects the physical failure modes of a circuit, fault analysis becomes a logical rather than a physical problem.
2. It is possible to construct logical fault models that are applicable to many different technologies, in which case fault analysis becomes relatively

TABLE 1  
REPRESENTATIVE PHYSICAL FAILURES IN ICS

Package wiring faults

On-chip metalization (aluminum) faults due to:

Corrosion

Electromigration

Microcracks

Bridging

Dielectric (silicon dioxide) faults due to:

Mask defects

Electrostatic discharge

Surface faults

Threshold shifts

Pattern sensitivity

Soft faults due to:

Alpha particles

Cosmic rays

technology-independent. This means that computer programs for fault simulation and test generation can be written that do not lose their usefulness with changes in technology.

3. Using logical fault models it may be possible to derive tests for faults whose physical reason is unknown, or whose effect on circuit behavior is not completely understood.

4. A logical fault model often covers a large number of different physical faults, resulting in a substantial decrease in the complexity of fault analysis.

Various criteria may be used for classifying both physical and logical faults; Table 2 lists the most important ones [Ref. 9].

TABLE 2  
PARAMETERS FOR CLASSIFYING FAULTS IN DIGITAL SYSTEMS

Variability with respect to time:

- Permanent
- Intermittent
- Transient

Number of primitive faults that may be present simultaneously:

- Single faults
- Multiple faults

Effect on components

Effect on interconnections between components

Effect on operating speed

Most of the studies have addressed the single stuck fault. A commonly used fault model is the Stuck-At model. A faulty gate input in a circuit is modeled as a Stuck-At-0

(S-A-0) or a Stuck-At-1 (S-A-1). When a certain number of input test vectors are applied to a circuit, the percentage fault coverage depends on the number of S-A-0 or S-A-1 faults that can be detected by the input test sequence as a percentage of the total number of single faults that might happen. Some other fault types are: multiple stuck-at faults, delay faults, pattern sensitive faults and short-circuit faults.

## 2. Stuck-At Model

This model does not take into account all possible defects, but is a more global type of model. It assumes that a logical gate input or output is fixed to either a logic 0 or a logic 1. For example, the faulty AND gate pictured in Figure 2.1 (b) perceives the A input as 1, even if the logic value 0 is placed on the input.

The pattern applied to the fault free AND gate in Figure 2.1 (a) has an output value of 0 since the input is 0 on the A input and 1 on the B input. But the pattern in Figure 2.1 (b) shows an output of 1, since the A input is perceived as a 1 even though a 0 is applied to that input. Therefore, the pattern shown in Figure 2.1 is a test for the A input, S-A-1, because the good machine responds differently from the faulty machine. [Ref. 8]

Techniques are available to decrease the complexity of fault simulation, however, it is still a time consuming and expensive task. It has been observed in [Ref. 8] that the computer run time to do test generation and fault simulation is approximately proportional to the number of logic gates to the power of 3.

The problem with CMOS is that there are a number of faults which could change a combinational network into a sequential network. Therefore, the combinational patterns are no longer effective in testing the circuit in all cases. [Ref. 10,11]

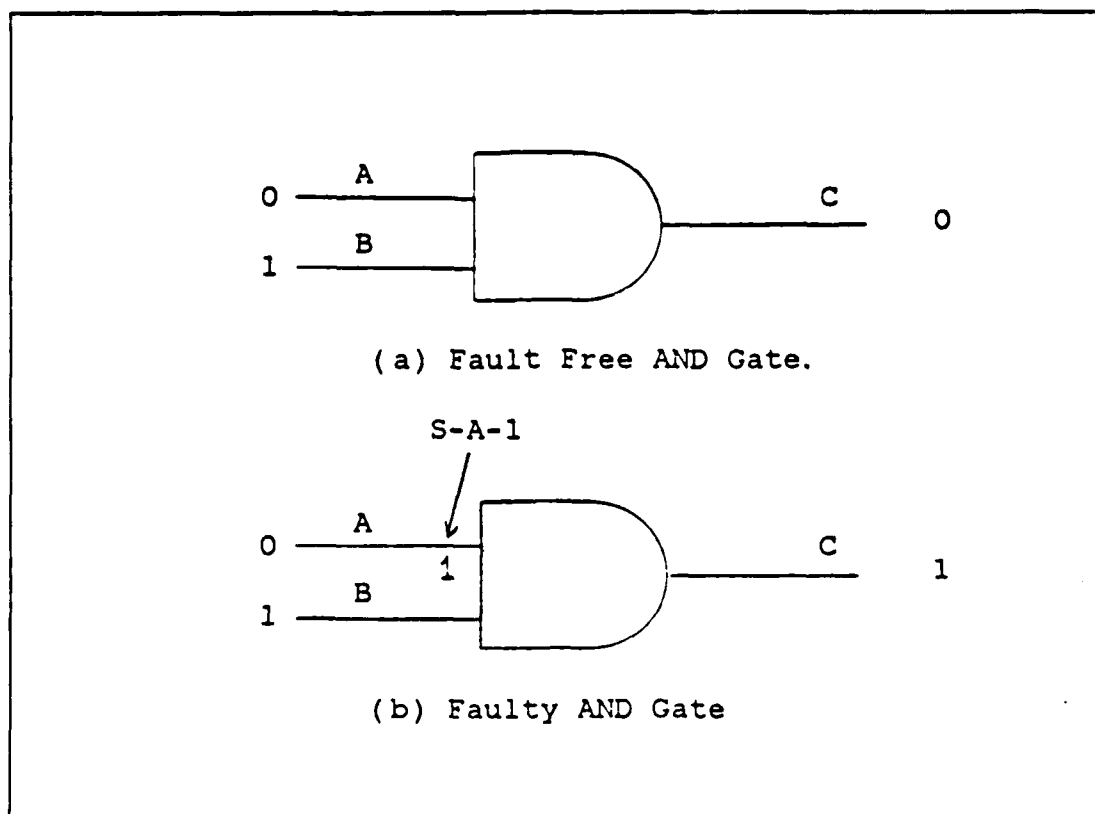


Figure 2.1 Test for input stuck at fault.

It was noted previously that single stuck-at fault test sets seem to provide acceptable levels of fault coverage for devices fabricated with current technology. Advances in VLSI technology are rapidly changing circuit characteristics, however, and it would be desirable to anticipate the effect of these changes on the occurrence of multiple faults. During the fabrication process a single surface defect or a variation in processing parameters can cause multiple faults. The major problem in developing test sets for multiple fault detection is the large number of possible faults. For example, it is calculated in [Ref. 12] that if we have a circuit with only 10 nodes there are 20 single stuck-at faults, 180 double faults, 960 triple faults, and 59048 possible stuck-at fault patterns. For

today's VLSI circuits, which may contain in excess of 100000 nodes, it can be easily seen that explicit test generation for anything other than single faults is impractical.

In summary, fault simulation has some difficulties in VLSI circuit applications. The increase in circuit complexity makes the simulation of all gate-level faults very time consuming. The gate level description of the VLSI chip must be available and good documentation is required. Consideration of only single stuck-at faults may be inadequate. Multiple faults, non-stuck type faults and suspended temporarily at intervals type faults are important but either difficult or impractical to process. [Ref. 9,11,12,13,14,15,16]

### 3. D Algorithm

The D-algorithm is a method for generating a test vector for a given fault. This algorithm, developed by Roth at IBM, is probably the most widely used test generation procedure [Ref. 17]. It is typically used with gate-level circuit models and stuck faults. The D-algorithm attempts to construct a sensitized path over which an error signal can propagate from the fault location to an observable primary output line. It systematically assigns values to lines associated with each potential sensitized path until a valid assignment is found, if one exists. Using a backtracking approach based on the circuit structure, the D-algorithm searches the space of possible test patterns for the given fault. The method in its most general form can always find a test or, in the case of an undetectable fault, prove that no test pattern exists for it. [Ref. 9,17,18]

It is worth noting that the D-algorithm is particularly well-suited to test generation for circuits designed using LSSD (Level Sensitive Scan Design) and similar techniques. A large number of practical test generation programs and algorithms are based on the D-algorithm. [Ref. 9]

With the vast increase in circuit density, the ability to generate test patterns automatically and conduct fault simulation with these patterns has decreased. As a result, some manufacturers are skipping these more difficult approaches and are accepting the risks of shipping a defective product. One general approach to reduce the cost of testing is embodied in a collection techniques known as Design for Testability. [Ref. 8]

### C. DESIGN FOR TESTABILITY

Design for testability is motivated by the need to reduce the costs associated with testing and maintaining a digital system over its working life. Major testability considerations include test generation difficulty, test sequence length, test application cost, fault coverage and fault resolution. The costs are basically those of the computer time required to run test pattern, personnel to write the test pattern programs and test equipment [Ref. 9]. The objective is to design circuits from the outset so that test verification and test generation efforts are limited in magnitude [Ref. 10].

Testability relies on designer awareness of two concepts called controllability and observability. Controllability is the ability to set and reset every node internal to the circuit. Observability is the ability to observe either directly or indirectly the state of any node in the circuit. There are programs that can compute controllability and observability for a given circuit [Ref. 19,20].

Three basic approaches to design for testability are ad hoc testing, a structured design approach, and self-test and built-in testing.



## 1. Ad Hoc Testing

Common techniques involve partitioning large sequential circuits and adding test points, but are not directed at solving the general sequential problem. The use of test and control points which attempt to improve local observability and controllability is basic guideline. Ad hoc techniques usually offer relief, and their cost is probably lower than the cost of the structured approaches. The ad hoc approaches use partitioning, test points, bus-structured design and signature analysis. [Ref. 8,10]

## 2. Structured Design for Testability

With the utilization of LSI and VLSI technology, it has become apparent that even more care has to be taken in the design stage in order to ensure testability and producibility of digital circuits. Most structured design practices are built upon the concept that if the values in all the latches can be controlled to any specific value and observed with a very straightforward operation, then the test generation, and possibly the fault task, can be reduced to that of doing test generation and fault simulation for a combinational logic network. It is stated in [Ref. 8] that several companies have been dedicating significant amounts of resources toward Structured Design for Testability. They have recognized that unstructured designs lead to unacceptable testing problems.

The most common techniques under structured design concept are: LSSD (Level-Sensitive Scan Design), Scan Path, Scan-set Logic Structures and Random Access Scan techniques [Ref. 8,9,21,22]. We only review the most popular approach -- IBM's LSSD discipline.

a. Level Sensitive Scan Design

With LSSD, the only type of storage element (other than arrays) permitted in a logic design is the SRL (shift register latch). Figure 2.2 from [Ref. 22] shows a typical SRL configuration. An SRL is a pair of polarity hold latches with the output of the first latch, L1, permanently connected to the data input of the second latch, L2. AIs represent and-invert gates and Ns represent nor gates. [Ref. 8,22]

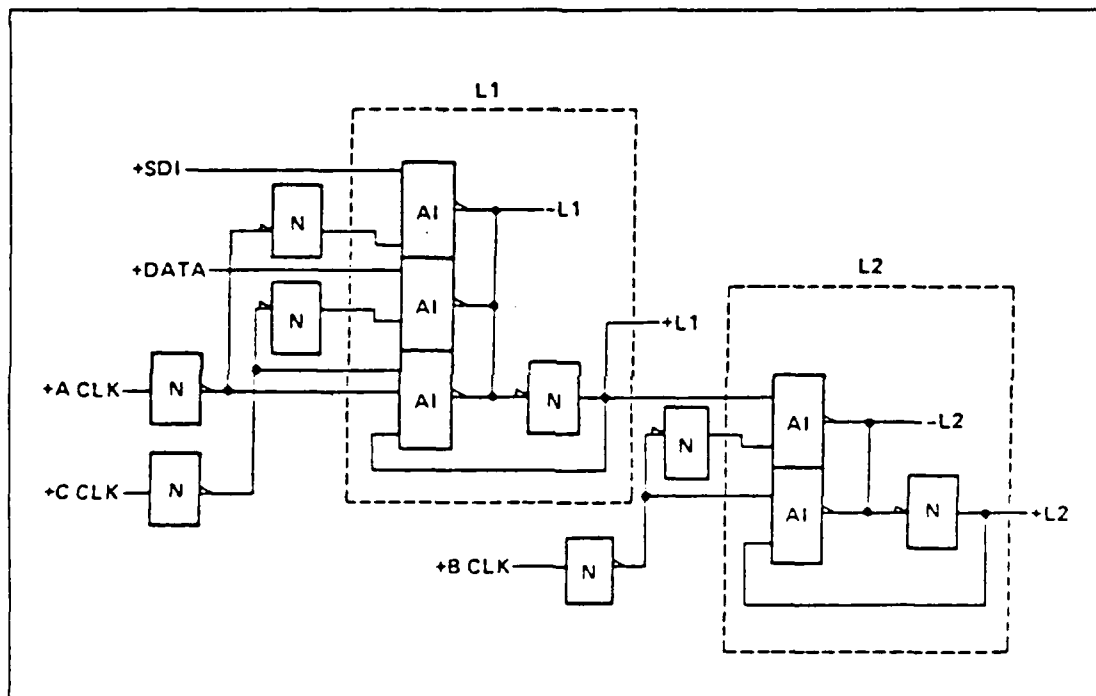


Figure 2.2 Shift Register Latch.

The L1 latch can be set either by the system data/clock or by the scan data/A clock because it functions as a storage element during system operation and as a component of the LSSD shift register during testing. All the SRLs on a chip are connected into a shift register with the input

to the first SRL designated Scan Data In and the output of the last SRL L2 latch designated Scan Data Out. In Figure 2.3 from [Ref. 22] the dashed line represents the shift path. Two chip inputs for the non-overlapping scan A and B clocks are connected in common to the SRLs L1 and L2. The designer has lost the use of four chip pins and the circuits required to implement the L2 latch and associated clock drivers, but the connection of the SRLs into a shift register in no way interferes with the normal functional operation of the chip. The four pins and the L2 latches enable the test system to control and retrieve the contents of any storage element on the chip by a simple shift technique.

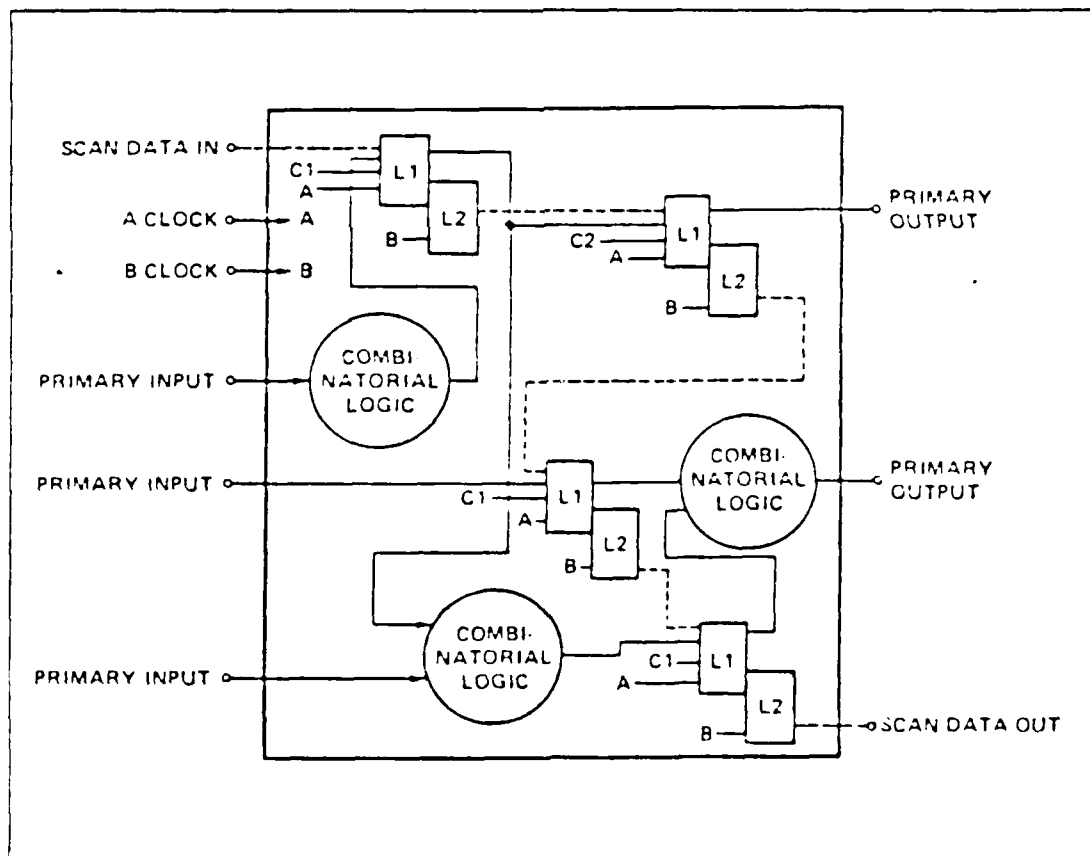


Figure 2.3 Typical LSSD Chip.

The only requirement during shifting is that all functional system clocks remain inactive so as not to interfere with the shift operation. In addition, all functional system clocks must be controllable at the inputs to the chip. These system clocks are C1 and C2 in Figure 2.3 .

The LSSD technique reduces the testing problem to one of generating tests for combinational logic. Test patterns are generated automatically with the assumption that each SRL is a pseudo primary input/pseudo primary output, and access to these inputs and outputs can be gained by shifting into or out of the shift register. These generated test patterns are scanned into the SRLs to simulate the combinatorial logic internal to the chip. Primary input stimuli are applied and system clock inputs are pulsed to capture the resulting state of the combinatorial logic. The shift register is then scanned out and examined for expected results which are obtained by simulation. In this manner the chip is tested for typically 98-100% of all DC stuck faults with program generated test data. [Ref. 22]

The cost of LSSD, on first look, is a significant overhead in unusable circuits. The L2 latch, the extra clock drivers (for the shift clocks), and the extra scan data input to the L1 all constitute circuits which must exist for testing, but are not available to the designer for his unrestricted use in implementing the processor function. These circuits represent the hardware cost of LSSD and can often approach 20% of the available circuits. [Ref. 22]

A typical application of the LSSD technique can be seen on the PLA cell design in Mathews and Newkirk's VLSI Designer's Library. [Ref. 23]

### 3. Built-in Test And Self-test

One approach to built-in test is known as BILBO (Built-In Logic Block Observation). It takes the Scan Path

and LSSD concept and integrates it with the Signature Analysis concept [Ref. 24]. A 3-bit register is shown in Figure 2.4 from [Ref. 10] with the associated circuitry. In mode A ( $C_0 = C_1 = 1$ ), the registers act as conventional parallel registers. The  $a_i$  values are loaded into the  $L_i$ , and the outputs are available on  $Q_i$ . In mode B ( $C_0 = C_1 = 0$ ), the registers act as scan registers. In mode C ( $C_0 = 1, C_1 = 0$ ), the registers act as a signature analyzer or pseudo-random sequence generator (PRSG). The registers are reset if  $C_0 = 0$  and  $C_1 = 1$ . Thus a complete test generation and observation arrangement can be implemented as shown in Figure 2.5, [Ref. 10]. The BILBO register on the left is used as the pseudo-random sequence generator. Its outputs are applied to the combinational circuitry. The combinational circuitry response are stored in the BILBC register on the right which is used as a signature analyzer. After a certain number of patterns have been applied, the signature is scanned out of the BILBO register and compared against the actual data. [Ref. 8,10]

In LSSD or other structured design techniques, a considerable amount of test data volume is involved with the shifting in and out. With BILBO, if 100 patterns are run between scan-outs, the test data volume may be reduced by factor of 100. The overhead for this technique is higher than for LSSD since about two EXCLUSIVE-OR's must be used per latch position. Also, there is more delay in the system data path.

Other techniques that are going to be introduced very briefly, are Syndrome Testing and Autonomous Testing. In syndrome testing, which requires exhaustive testing, all possible inputs are applied to the circuit and the number of 1's at the output are counted. The resultant value is compared with that of a known good machine. Extra circuitry

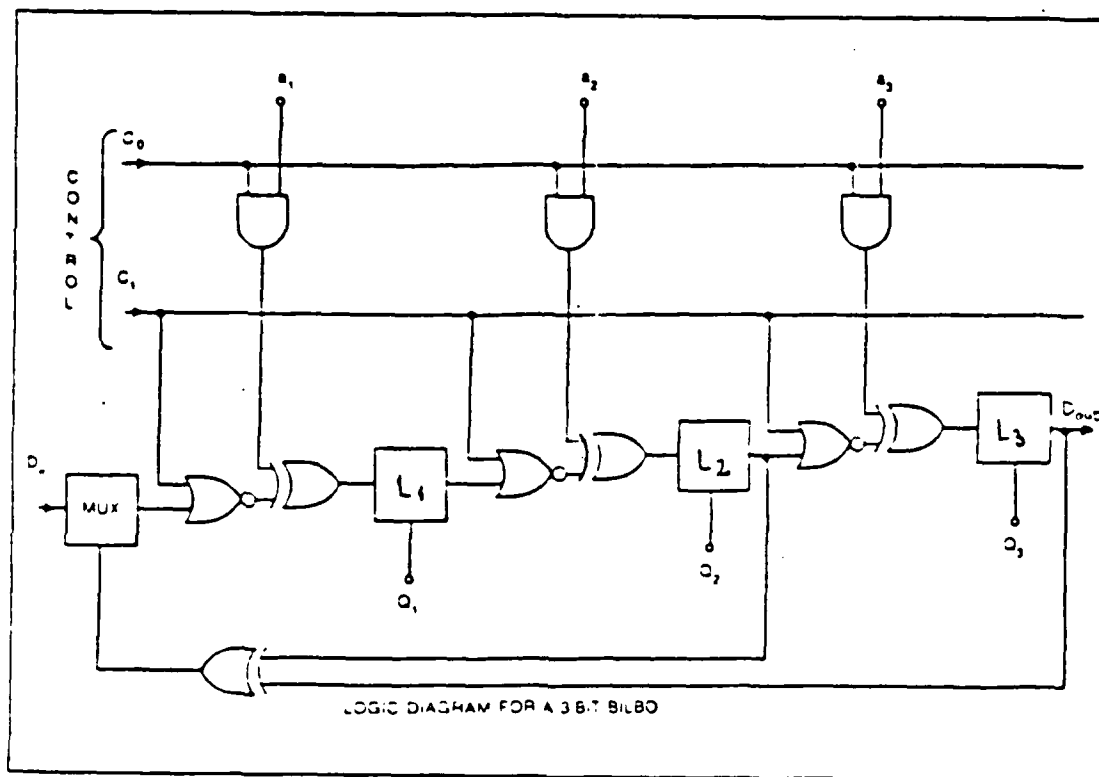


Figure 2.4 BILBO Usage.

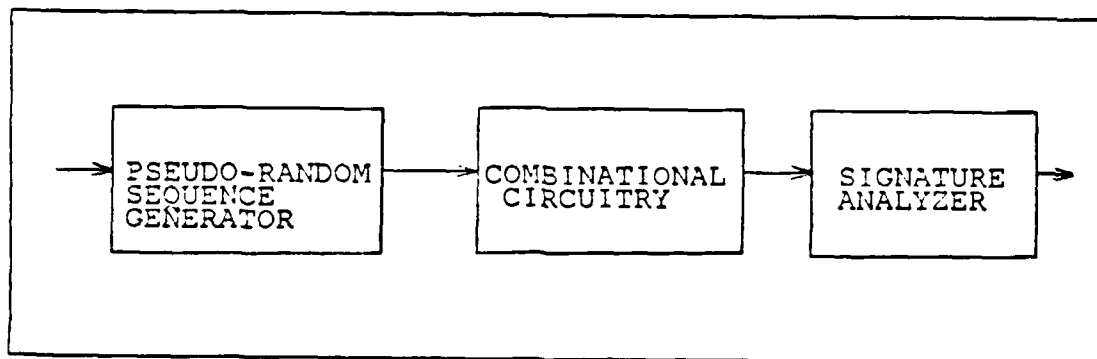


Figure 2.5 BILBO Circuitry.

includes a pattern generator, a counter, and a comparison circuit. [Ref. 8,10,25,26]

On the other hand, in the autonomous test approach, modules are partitioned into small modules, which are then tested exhaustively. [Ref. 8,10,15]

#### D. SIGNATURE ANALYSIS

Compact testing methods attempt to solve the problem of analyzing and storing the large amount of response data which is required for a good response generation. It is possible to compact response data  $R$  into a form  $f(R)$  which includes most of the fault information. This eliminates the need for a large memory and additional circuit units.

A general form of a signature of the data  $a, b, c, \dots$  is any function  $f(a, b, c, \dots)$ . This function can be used as sufficient evidence of the presence of a particular data set, just like a person's signature on a check. It's not absolute proof of the presence of the data, however.

The signature analysis technique was introduced in 1977 [Ref. 27]. This technique should only be used when it is not feasible to compare test result data against actual data. There is no advantage to using signature analysis if the actual data is available at the same rate and in synchronism with the data being tested. It is a useful tool when properly utilized [Ref. 28].

Regarding the concept of design for testability, it falls between the ad hoc and the structured approaches for testable design. It is well-suited to bus structure architectures, in particular, those associated with microcomputers. The key to signature analysis is to design a network which can excite itself. Such a network could be microprocessor-based boards, since they can stimulate themselves using the intelligence of the processor driven by the memory on the board [Ref. 8].

##### 1. Signature Analyzing

The initial part of the approach is a linear feedback shift register (LFSR). An example of a 3-bit LFSR is shown in Figure 2.6. This linear feedback shift register is made up of three latches. The upper exclusive-or gate

takes its inputs from the second and third bit in the shift register and the result is the input to the first latch. A LFSR counts for different initial values.

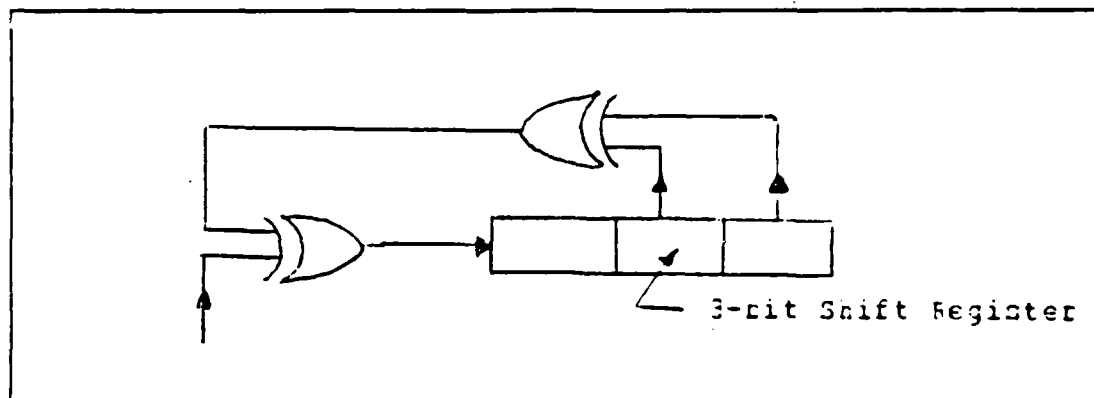


Figure 2.6 A Linear Feedback Shift Register.

For larger shift registers, the maximal length of the linear feedback configurations can be obtained by consulting tables in [Ref. 29] to determine where to tap off the LFSR to perform the exclusive-or function. Only exclusive-or blocks can be used, since this preserves the linearity. The Signature Analysis procedure is external to the board and a probe is used to probe a particular net on the board as shown in Figure 2.7.

Let us suppose a bit stream of length  $n$  is fed to a serial data input line. There are  $2^n$  possible combinations of data streams and each one will be compressed to one of the  $2^3$  possible signatures. An LFSR has the property of equally distributing the different combinations of data streams over the different signatures [Ref. 30]. For example, for  $n = 3$  each data stream will be mapped to a distinctive signature (one-to-one mapping).

For  $n = 4$  exactly two data streams will be mapped to the same signature. Thus, for a particular data stream



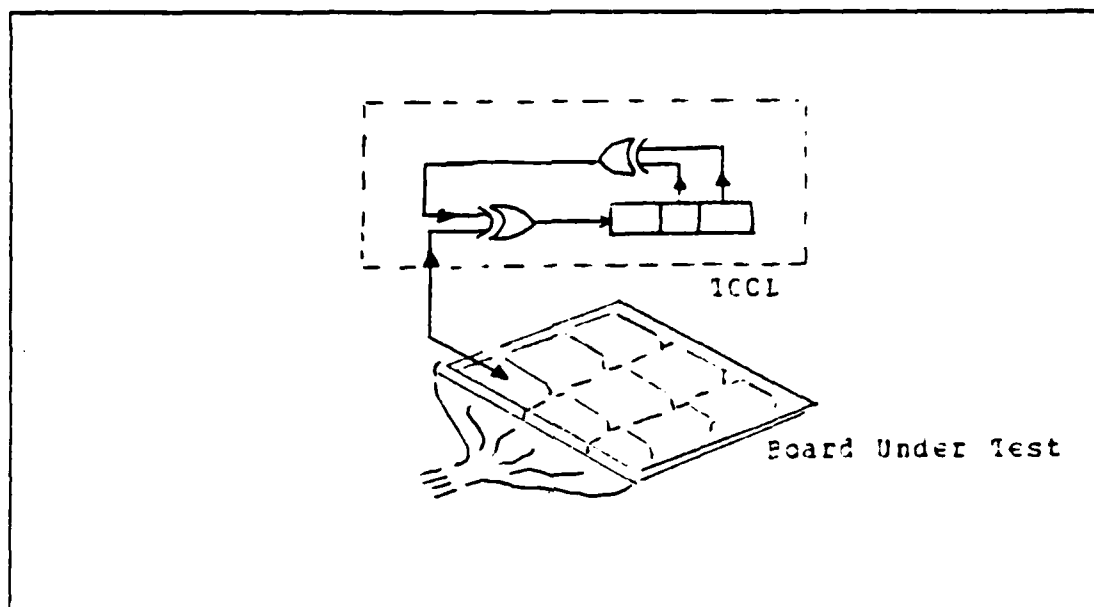


Figure 2.7 Use of Signature Analysis Tool.

(good response), there is only one other data stream (a faulty output response) that will have the same signature; i.e., only one faulty response out of  $2^4 - 1$  possible faulty responses will not be detected.

In general, for any response data stream of length  $n > 4$ , the probability of missing a faulty response when using 3-bit signature analyzer is

$$\frac{2^{n-3} - 1}{2^n - 1} \approx 2^{-3} \quad \text{for } n \gg 4$$

It has been shown that the probability of detecting one or more errors is extremely high if a 16-bit LFSR is used [Ref. 6].

The question is: if there were errors present at one or more points in the string of observations of that particular net of the board, would the value stored in the shift register (for each latch) be different than the one

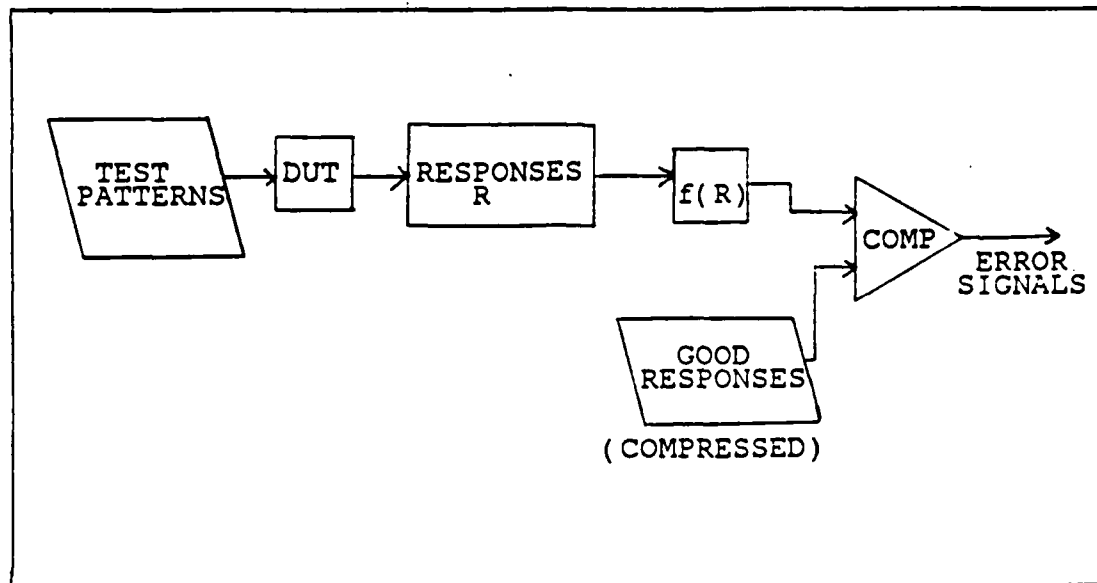


Figure 2.8 Compact Testing.

for the good machine ?. For each compression function  $f$  shown in Figure 2.8, there is a slight probability that a response  $R_1$  different from the fault-free response  $R_0$  which will be compressed to a form equal to  $f(R_0)$ , i.e.,  $f(R_1) = f(R_0)$ . If this happens, the fault causing the device under test to produce  $R_1$  instead of  $R_0$  won't be detected.

## 2. Advantages

The major advantage is that this approach does away with the requirement for the actual data at the actual rate and in synchronism, and the requirement for testing of functionality. This reduces the cost [Ref. 28].

The hardware to compute typical signature functions is inexpensive, and can be fast, while at the same time permitting the go/no-go decision to be made slowly at software speeds [Ref. 28].

### 3. Disadvantages

The major disadvantage of signature analysis is that it is difficult to derive any information from the signature beyond a yes/no decision. It is hard to diagnose failures from the failing signature. Consequently, a failure in one node will cause failures to be observed at any other nodes [Ref. 28].

Most signature functions involve a tradeoff between the probability of error detection and diagnostic capability. For example, transition count based functions provide better diagnostic capabilities than the popular polynomial function; the latter provides a higher probability of error detection, but knowing the logical distance between the expected signature and the failing signature unfortunately provides no knowledge about the distance between the expected data and the failing data either in time (indicating when the failure might have occurred) or in space (as to how wrong the failing data was) [Ref. 28].

Another problem with signature analysis is the volume of information that is contained in the signatures, even though this is substantially less than the volume of information contained in the actual data stream itself. On a device under test with 1000 nodes, this implies a similar number of measurements [Ref. 28].

### 4. Other Techniques

There are extensions which use some other techniques in combination with signature analysis. The scheme proposed in [Ref. 31], called Pseudo-Exhaustive Testing using Signature Analysis, provides a function independent testing sequence for sequential machines. Signature and Parity Testing Techniques can be combined to solve the error masking problem which arises during the testing of multiple output circuits. Encoding the contents of the compacting

LFSR device using linear block codes is done to recognize combinations of parity faults in the multiple outputs of the function [Ref. 32].

Despite the possibility of missing an error which is very small (on the order of 0.002 percent), the Signature Analysis technique requires only very simple hardware circuitry and a small amount of memory for storing the good signatures. It is also not sensitive to the order of the test pattern. Signature Analysis, like any other tool, has its advantages and limitations but it is useful for testing if properly applied and combined with other techniques.

#### E. CAD/CAT

Computer-Aided Design (CAD) of integrated circuits has had various interpretations as a function of time and definition source. These interpretations range from use of simple, interactive graphics and digitizing systems to individual programs used for circuit or logic simulation, mask layout, and data manipulation or reformatting. The computer aids or tools provide the designer with a rapid and orderly method for combining and evaluating design ideas and relieve the designer of numerous routine and design steps. The use of computer aids in the layout of IC masks essentially proceeded along two approaches: interactive graphics systems and automatic layout based on standard cells. Early interactive graphic systems provided a method for capturing the design by recording coordinate information by manually digitizing and editing data. Methods for superimposing mask layers, scaling, enlarging, contrasting, and reviewing the results were expanded to provide fast, sophisticated drawing commands for constructing, editing, and reproducing complex figures. [Ref. 33]

In developing VLSI systems with a CAD environment, system engineering and information processing tasks of many people must be coordinated. The coming generation of integrated CAD environments is changing the work habits of individual designers and operation of VLSI system development organizations. On the other hand, overcoming the complexity of advanced VLSI systems requires substantial effort in organizing many people with increasingly specialized skills. [Ref. 34]

Some unique CAD principles have been developed and proven to be very effective when used in conjunction with other engineering management concepts. As stated in [Ref. 35], a number of these principles are summarized below:

#### 1. System Aspects

1. Successful CAD optimizes both individual programs and the CAD system.
2. The overall CAD system has a higher productivity than any individual program.
3. Consistent engineer interfaces are imperative.
4. A data base system can improve CAD operation, but an enormously large data base may make the system very unwieldy and difficult to use.
5. An expert-system may be complex, but a simpler system may have only limited usefulness.

#### 2. Software Development

1. The support and tuning of programs are often larger tasks than the original development task.
2. Interfacing and debugging is never complete.
3. There is a minimum level of CAD support required, irrespective of the number of people using the program.
4. Only develop a program if it makes a major contribution.
5. Expect programs to change and eventually die.
6. Make sure when starting a project that the capability will be needed when the project is concluded.

### 3. Hardware Selection

1. There is no optimum computer for CAD; if there were, it would not be optimum in six months.
2. Hardware costs less than software.
3. Distributed computing means more than machine to machine communication.

### 4. CAD Impact on Design

1. CAD must be user driven. CAD must support the present user while developing for the future.
2. The CAD activity is not a good controller of the design process and cannot effectively mediate between designers.
3. Design is a creative process and the designers' creativity often leads to differences in design approaches.
4. Engineers stop verifying and optimizing their project only when it is too painful to continue.

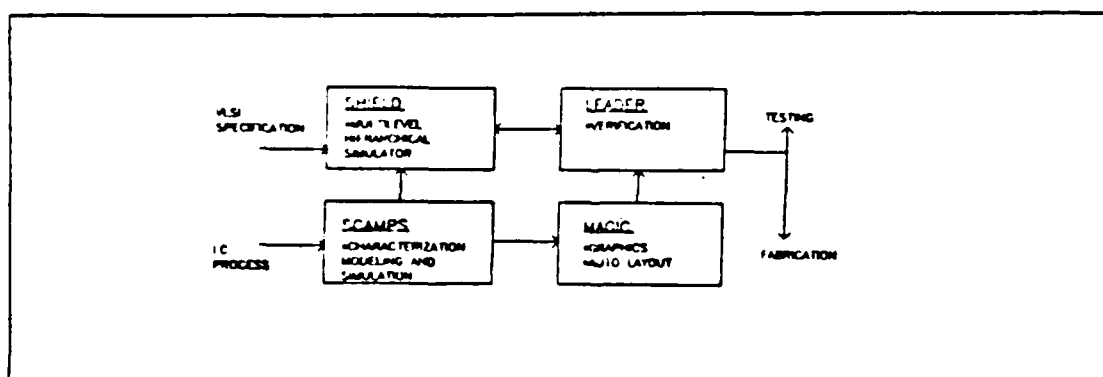


Figure 2.9 VISTA Software Overview.

Sophisticated CAD systems have been developed. As a typical example of CAD for VLSI we provide an overview of the VISTA (VLSI Simulation Test and Artwork) system which was introduced in [Ref 35]. Most of the principles above were experimentally generated through the experience of

designing and implementing the VISTA system whose software configuration is shown in Figure 2.9 from [Ref. 35]. A VISTA workstation consists of a physically small computer with approximately 1/4 the CPU power of the midi-computers being used. Each workstation is connected to four intelligent terminals ( Figure 2.10 ) two of which are color graphic stations. The entire VISTA CAD system may be run on the workstation as well as on the larger midi computers. Larger mainframes are used for batch jobs which consume extensive computer time. The system is extremely flexible allowing a user to share computer resources as well as files. [Ref. 35]

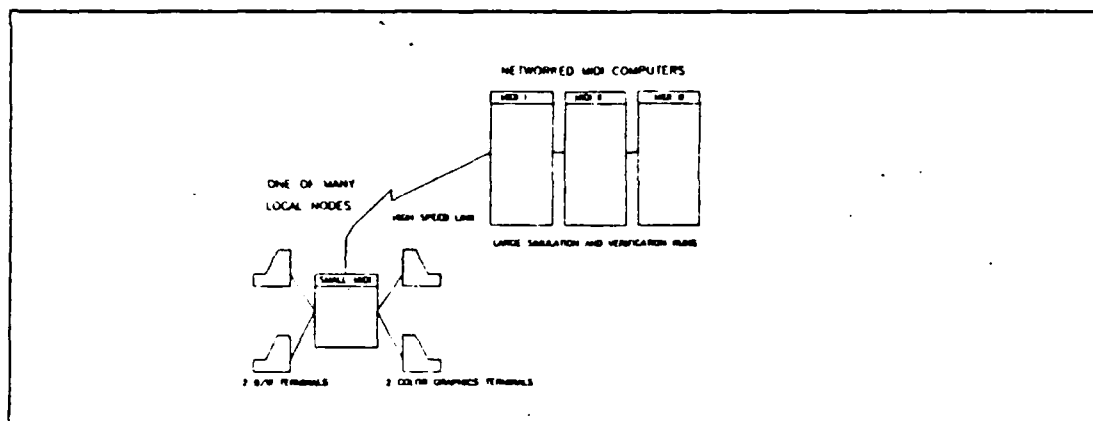


Figure 2.10 VISTA Hardware Configuration.

The design methodology of custom VLSI devices, however, may yield data for test use and may also allow the device designer to use that data in a semiautomatic manner on low-volume prototype devices. A successful Computer-Aided Testing (CAT) system recognizes that design data exists in many forms during the IC design lifecycle. While device designers may not have a test background, the test expertise may be shared by extracting functional pattern data from the IC design flow and transferring it to the appropriate

production test and/or benchtop debugging equipment. Usually this means capturing the test vectors that were used during logic simulation and reusing them for test purposes. This ensures that prototype IC devices can be functionally verified with the same test patterns used during logic simulation. In CAT design, extendability of the system into other simulation and testing environments is an important consideration. A properly designed, intermediate pattern format standard would allow a CAT system to grow into new simulation and test environments without impacting an existing system. A new logic simulator or piece of test equipment can be supported by developing a format-conversion program without re-doing major portions of the existing system. This concept is important when testing organizations support a variety of IC design methodologies. [Ref. 36]

#### F. TEST EQUIPMENT AND METHODS

Circuit complexity, a large number of inputs, clock signals and outputs, or the multitude of possible states may make manual testing prohibitively time-consuming. In general it will be necessary to use a computer to exercise the chip. A simple test system is illustrated in Figure 2.11 .

Properly defined test vectors, provided by the computer's output port, are applied to the input of the device under test. The response vector of the device under test is compared to a stored correct response by the computer which is programmed to respond with an error message upon detecting deviation from the expected pattern. [Ref. 1]

A minimal test system could consist of a general purpose test board with a tristate driver and read buffer connected to each pin, a couple of latches to store the state of the input and/or output variable at each pin, and a communication interface to the computer. [Ref. 1]



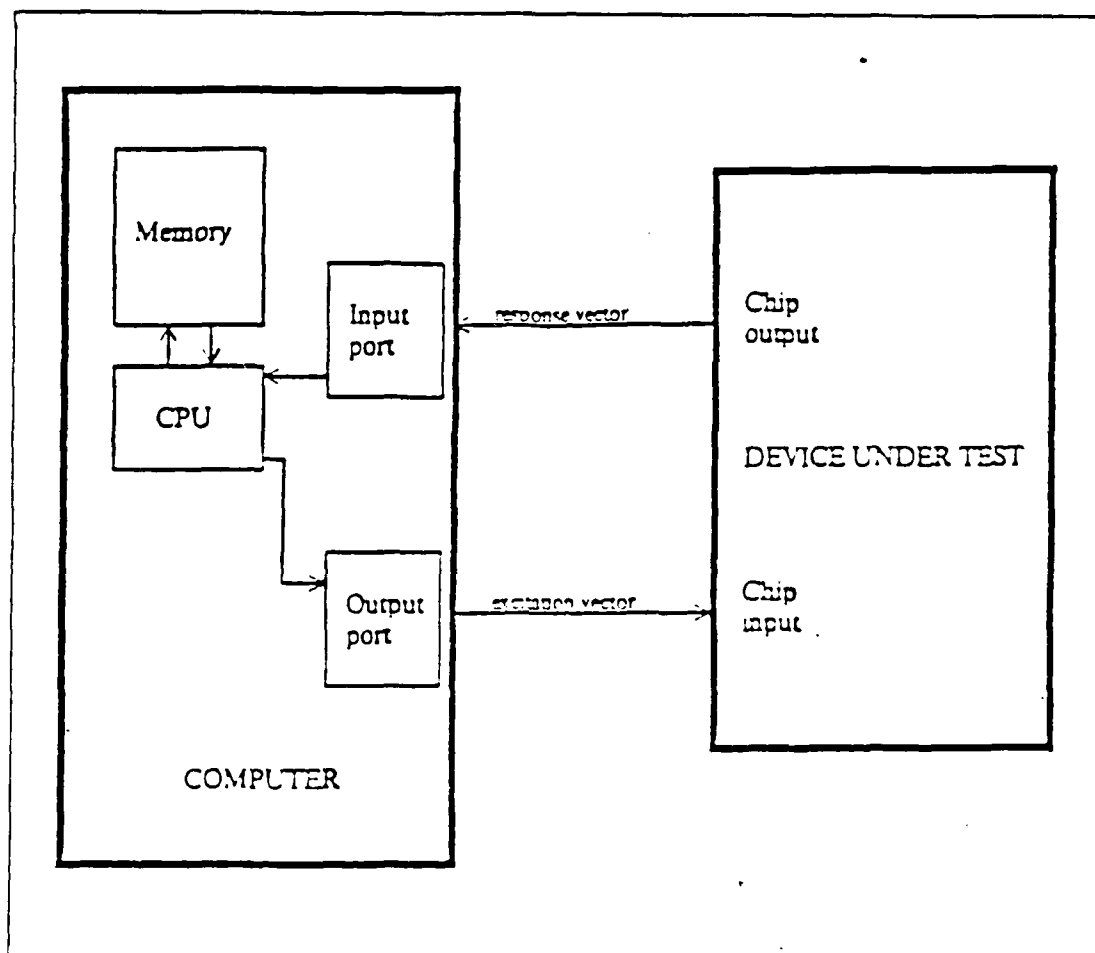


Figure 2.11 Simple Test System.

A software-based testing system might not be fast enough to capture some quickly changing response vectors, or it may have trouble exercising a complex device which may require some minimum clock rates for proper operation. Higher speed performance can be obtained with a parallel link to the computer. (If the excitation vector is wider than the typical 8 or 16 bit link to the host computer, the vector may be transmitted in several pieces and assembled in a set of registers on the interface board). Even higher I/O vector speeds can be obtained by moving more functions from software into hardware. An improved tester could use

semiconductor memory to store the excitation (test) and response vectors of a whole test sequence. The captured response vector can later be analyzed at a slower rate. [Ref. 1,37]

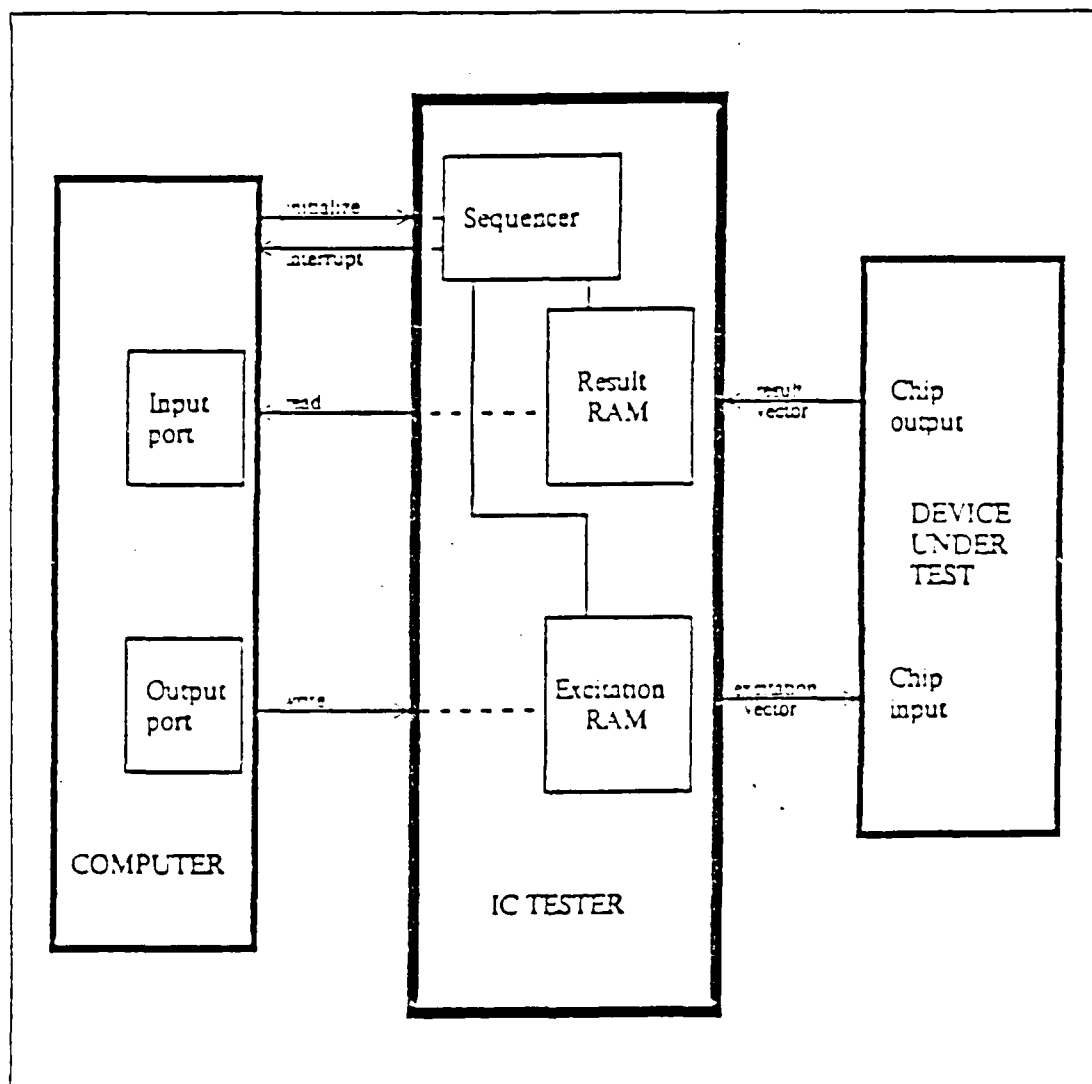


Figure 2.12 Hardware Approach to IC Testing.

The tester shown in Figure 2.12 from [Ref. 1] is a peripheral device to the host computer. The two advantages

of self contained testing hardware are: first it allows higher testing speeds and second it frees the computer to perform other tasks while testing is in progress. The excitation or test vector for the device under test can be understood as a set of control words emanating from a computer's control unit, with the result vector out of the device acting as a condition vector to this control unit. The tester thus takes the form of a microprogrammed controller. A tester based on this principle can exercise very complex devices due to its inherent ability to make logical decisions based on some of the results. When the test is concluded, relevant results are as before stored in a result RAM, and the host computer is signaled to fetch them. This kind of tester can be adapted to new tasks by changing the microcode stored in the excitation RAM shown in Figure 2.13. The tester may even do suitable branching dependent on the outcome of a few preliminary tests. [Ref. 1]

Almost any computer or microcomputer can be used as the host. The only requirement is that it has an accessible I/O port. The control unit for the tester could be built using one of the fast bipolar bit-slice microprocessors. The proper custom made interface board between the chip and the test system has to be built and the test routines have to be written. [Ref. 1]

One example of a VLSI test architecture is a Z8001-based single board computer with some additional memory and logic, and an interface to the device under test ( Figure 2.14 from [Ref. 38] ). The process involves creating a test program using the device assembler on a host computer. The program is downloaded to the VLSI tester where it executes. The results are captured in a trace memory and are sent back to the host. The host software then translates the results into

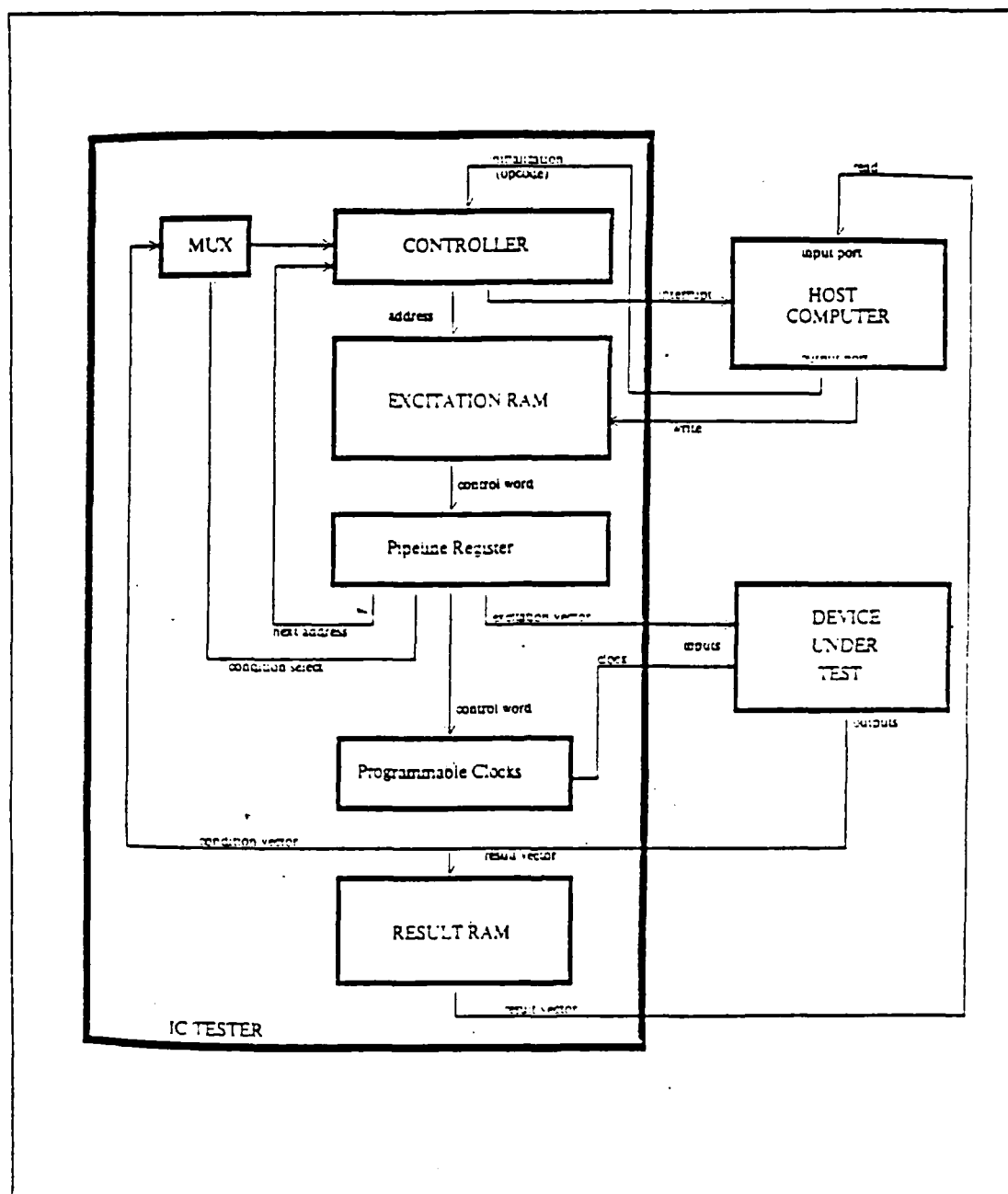


Figure 2.13 Microprogrammed IC Tester.

a device-oriented test pattern. The operating system allows the user to load programs to and from a host computer, to execute programs and to display or edit device under test

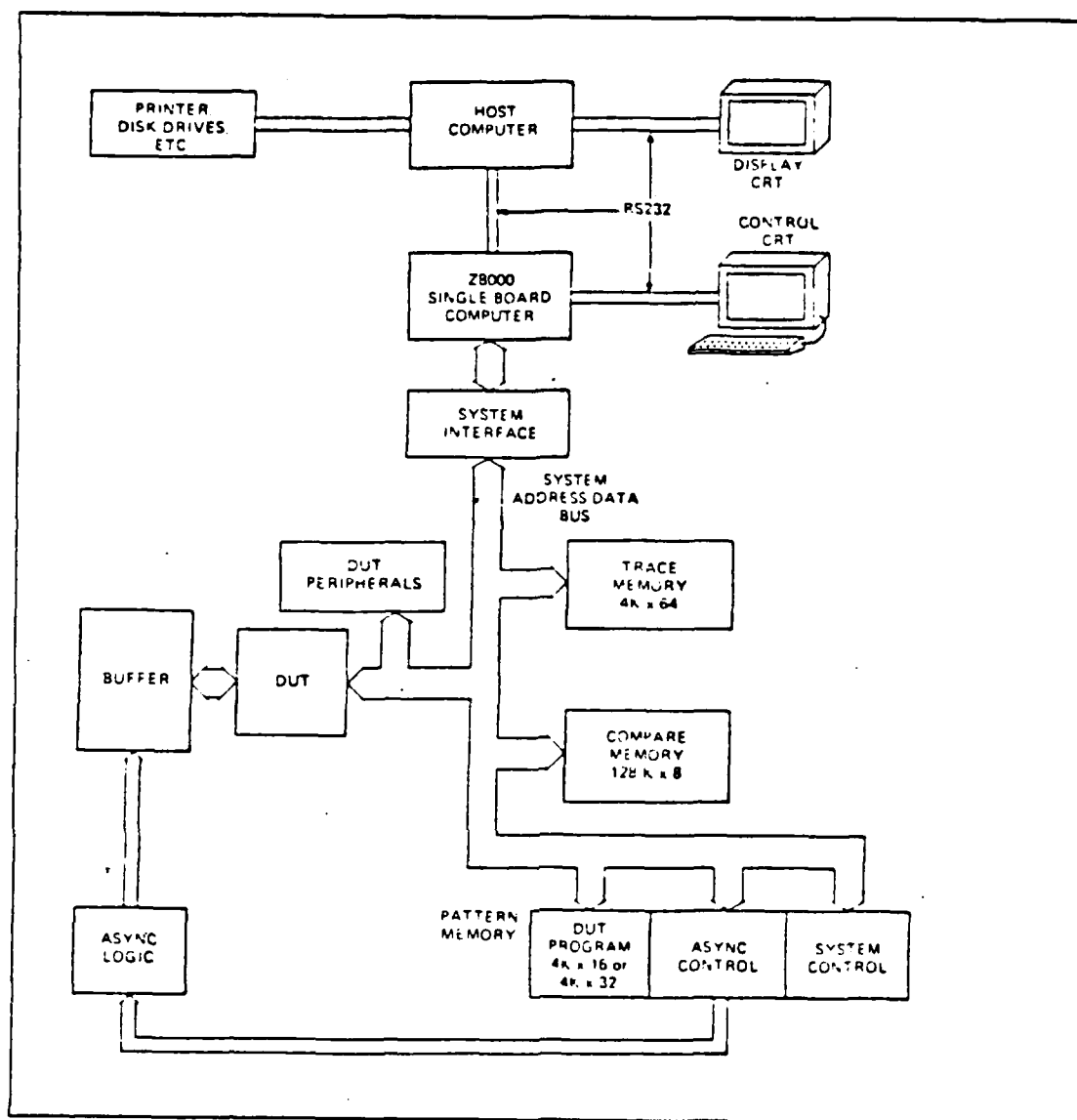


Figure 2.14 VLSI Tester Block Diagram.

registers, memory and test results, and to compare or move memory blocks. [Ref. 38]

## G. TEST SOFTWARE

Testing complex LSI and especially VLSI circuits requires the generation of a large number of test vectors. To address these problems, a test software system has been developed and introduced in [Ref. 39]. The test software system consists of three software elements shown in Figure 2.5. The first element of the system is the Test Vector Assembler. It accepts symbolic microcode written in a register transfer language with many higher level constructs. These higher level constructs allow the automatic generation of large numbers of test vectors from very short and simple specifications.

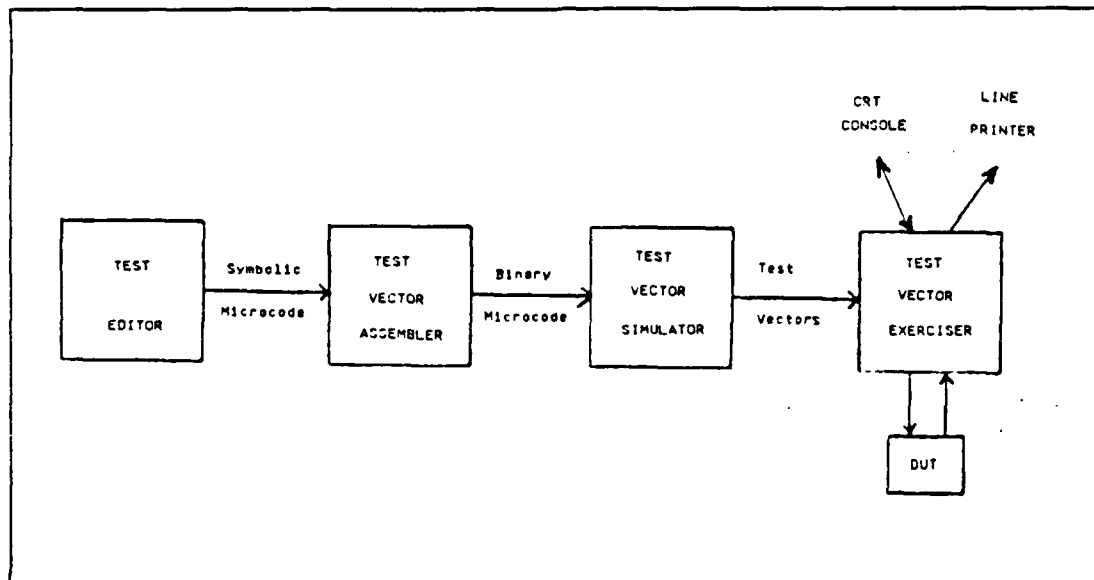


Figure 2.15 CAT System-Software Overview.

The second element of the test software system is the Test Vector Simulator which contains a software model of the device under test data paths and storage elements. The model computes the next state and output configuration of the device under test based on its current state and the test

vectors applied. As a result, the test vectors specified in the binary microcode are augmented with the corresponding expected responses, thus completing the test vectors.

The third element of the test software system is the Test Vector Exerciser software. This program facilitates interactive control of the actual execution of the test. It also has special features to aid the test engineer in performing fault isolation and diagnosis.

The test software system is implemented on an Intel microcomputer development system computer which is the basis for an in-house LSI/VLSI test system, the QTS-IV. The computer itself is based around an Intel 8080 microprocessor with 64K bytes of memory, dual single density floppy disks, CRT/keyboard, line printer and integrated circuit test head. All programs are written in PL/M, an Intel language, and they run under the ISIS-II Operating System. [Ref. 39]

Besides software systems, there are modern test languages. The extensions that make the following high level languages into test languages are discussed and introduced in [Ref. 40,41,42,43,44]. Pascal can be extended for test pattern generation and special purpose controller programming which are tasks that are specific to ATE. Pascal-T is also a test language that permits unlimited control of test functions while retaining the ease-of-use features of a high level language. PLT (Programming Language for Testers), designed by IBM, allows the user to perform functional testing of a product in an event driven mode at the functional speed of the product [Ref. 44].

ICTEST is an algorithmic language for describing functional tests of digital integrated circuits [Ref. 45]. The test stimulus and response specification is high level, with the ICTEST system handling the translation into a test vector. The idea behind the ICTEST system structure shown in Figure 2.16 is to unify testing and simulation. The designer

writes one test description that can be compiled for any of the functional simulators and testers in the system. Currently, tests target to either of two simulators or three testers.

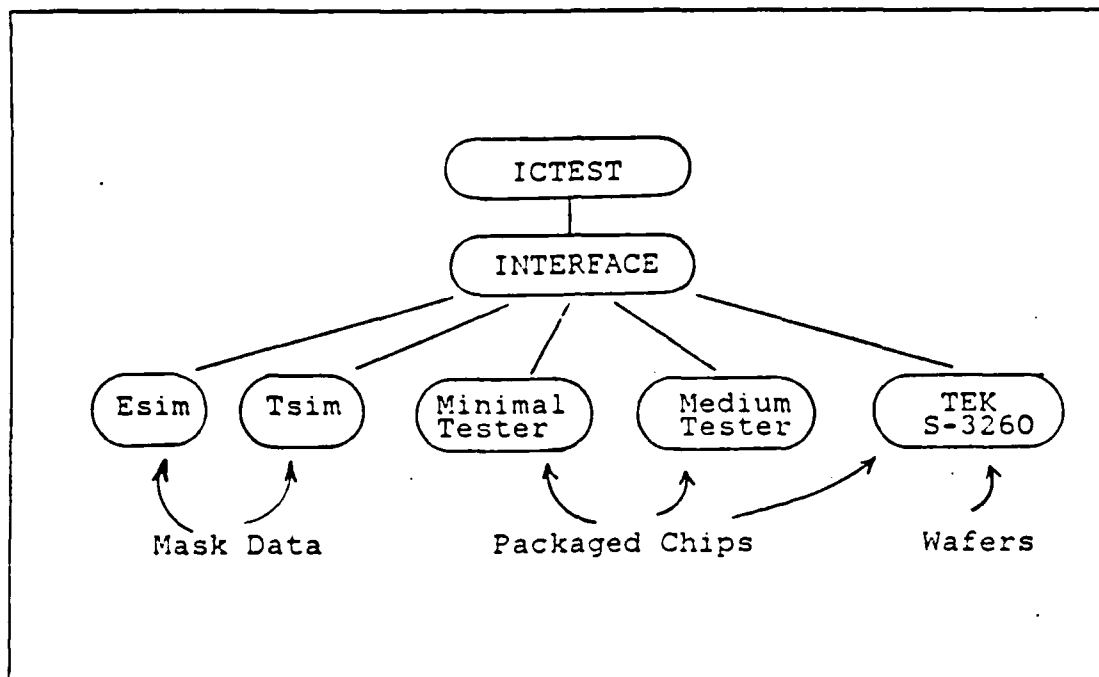


Figure 2.16 The ICTEST System.

ICTEST itself, the interface programs, and the esim and tsim switch level simulators run on a VAX-11/780. The VAX communicates with the testers over serial links. The MINIMAL tester can test 40-pin devices at a maximum of 1000 drive or sense operations per second; the MEDIUM tester, 80 pins at 100000 operations per second; the TEK tester, 64 pins at 5000000 operations per second, all pins simultaneously. ICTEST is an embedding of testing features in the C language. C is an Algol-like language which is similar to Pascal. The full power of C is available for describing tests algorithmically. [Ref. 45]



## H. ECONOMY OF TESTING

In general there is always the possibility that a chip doesn't function as desired. This must be detected through testing and, if caused by a design flaw, the chip has to be refabricated and retested. These steps are illustrated in Figure 2.17 .

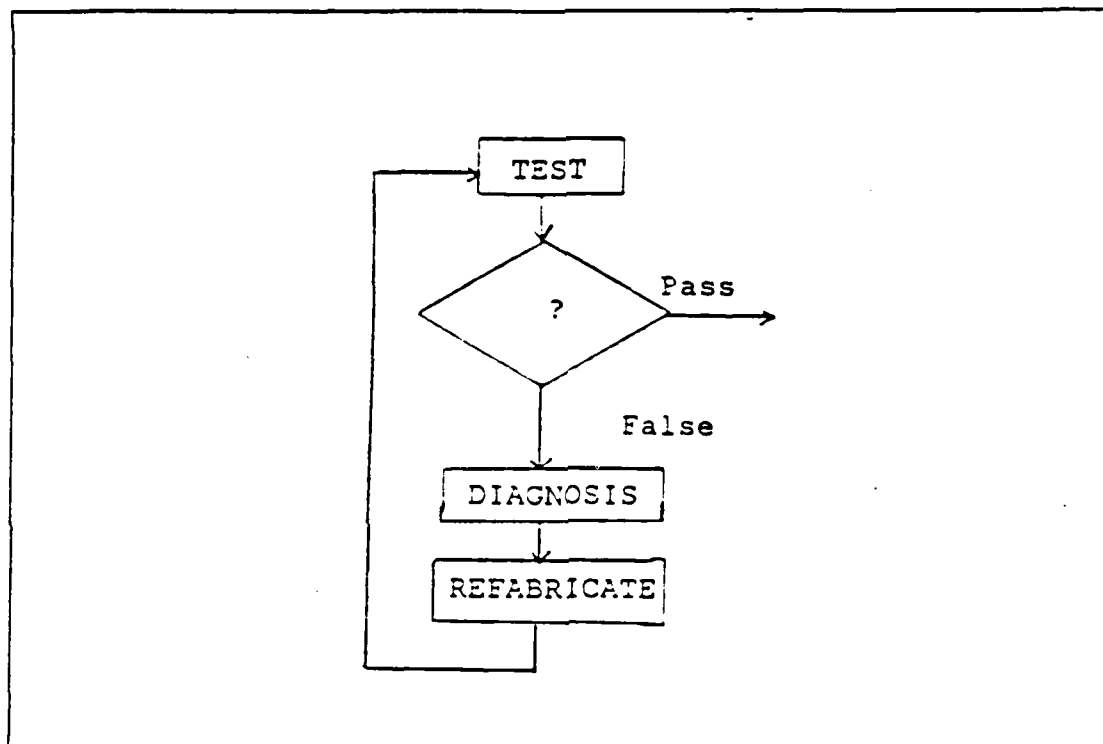


Figure 2.17 Basic Flow of Test Process.

There have been some studies concerned with modeling this process by using algebraic equations [Ref. 46,47,48,49,50]. The purpose is to determine the effectiveness of the process and fault coverage of the tester, and to estimate cost or throughput.

If the cost is \$0.30 to detect a fault at the chip level, then it would cost \$3 to detect that same fault when

it was embedded at the board level; \$30 when it is embedded at the system level. With VLSI and the inadequacy of automatic test generation and fault simulation, there is considerable difficulty in obtaining a satisfactory level of testability. Thus, if a fault can be detected at the chip or board level, then significantly larger cost per fault can be avoided at subsequent levels [Ref. 8].

The drop in costs and the increase in throughput occur as detected faults drop no matter what kind of method is used [Ref. 46]. On the other hand, faults are not easily controlled, so much effort has to be spent to reduce them.

Test program development has become an increasingly complex and time consuming task and development costs are primarily dependent on programmer and machine time investments. A remote program management approach has been proposed to save in manpower and test system utilization. The benefits and disadvantages of this programming approach are discussed in [Ref. 51].

Programmer effectiveness and selection of test strategy are also critical issues for testing. Important productivity gains can be made in a test organization by improving programmer effectiveness and selecting a best test strategy can provide maximum return on investment. These are studied and quantified in [Ref. 52,53].

It is recommended that critical circuit paths and area of possible marginal performance be clearly stated prior to testing. This is contrary to the common belief that only by revealing such areas of potential weakness is reliable testing demonstrated. Knowledge concerning possible circuit limitations allows tests to focus more on these areas while still providing general tests of circuit functionality. In this way, the overall effectiveness of testing can be improved and the cost decreased.

### III. REQUIREMENTS FOR TESTING

We have considered the most popular currently available approaches and some systems for testing of integrated circuits. It is observed that the functional test strategy is an appropriate approach in an academic environment which produces a few designs a year. This is why the introduction of the functional testing approach was left to this chapter. After examining the functional test strategy, it will be explained why we decided to use this approach.

#### A. FUNCTIONAL TEST STRATEGY

Functional testing is basically a test strategy which attempts to verify correct functional operation of a digital circuit according to its specifications. A complete test can be generated considering only the desired operation of a good system. What is expected from the functional testing approach is that complex systems can be quickly tested to see if they perform their intended functions. Functional faults with respect to functional specifications can be tested by using a representation of a circuit higher than its gate level. (We have not encountered any clear and strong attempts to formalize functional testing). Generally speaking, functional testing is the differentiation of faulty integrated circuits from good circuits which satisfy their functional requirements. An integrated circuit can be functionally tested by stimulating it with a carefully defined input test sequence and then comparing its response with a stored correct sequence.

## B. WHY FUNCTIONAL TEST

The exhaustive testing approach and the other methods derived from it often require an unacceptable amount of test time and memory space to go through all possible steps. A circuit with 24 inputs and 32 bits of memory has  $2^{32}$  or approximately  $4 \times 10^9$  different internal states. There are  $2^{24}$  or approximately  $16 \times 10^6$  possible input patterns. An exhaustive test would require approximately  $7 \times 10^{10}$  test vectors. With the capability of 10 million test steps (10 MHz) per second, it would take more than 200 years. Thus, exhaustive testing is good for only small systems.

Fault simulation and fault modeling techniques are very useful in describing physical failures in small and medium scale circuits (especially TTL). However, today's circuits on a chip may not have a simple correspondence with gate level logical descriptions. There are many cases where failures cannot be represented by the stuck-at models [Ref. 10]. Representation of a single faulty circuit which has no simple gate level correspondence would require a large number of gates. On the other hand, stuck-at models are the only computationally efficient and quantitative measure of test effectiveness [Ref. 14]. But when we consider today's complex LSI/VLSI circuitry this method is time consuming and requires detailed gate level descriptions of circuits. Since a detailed circuit description of a chip is often not available, functional testing becomes important.

Signature Analysis seems a more economical and attractive way to perform testing because of data compression and the requirement of very simple circuitry. Even though the volume of information contained in this method is less than the actual data stream itself, it still implies time consuming measurements.

Once we agree on the functional test strategy which is the best for our environment under today's circumstances, we

can first examine ways of using simulation data as test and reference vectors and then consider possible basic characteristics of a functional tester.

### C. USING SIMULATION DATA AS TEST AND REFERENCE VECTORS

One way to extract test and reference data vectors is to drive a tester with ESIM files which are generated during the design layout phase. This approach, illustrated in Figure 3.1, is designed and implemented (except for the communication and hardware interfaces between microcomputer and tester) in [Ref. 54] as a thesis project. The ESIM files for a particular VLSI circuit consist of pin designations, initialization vectors, clocking sequences, test inputs and the corresponding output vectors. Test data from ESIM files are extracted by an "Extract Test Data" software subsystem. This software program is implemented on a VAX-11/780 computer system in order not to be restricted by the memory capability of a microcomputer. This program changes the available node data into the test vector format, and writes out these vectors into an external file. This data file is then converted into the microcomputer operating system data format and then transferred to an 8" floppy disk.

The VLSI circuit is simulated either from test files or from data entered through the keyboard interactively. After initialization of the tester and the device under test, each test vector is applied to the device under test and the resulting response is compared with the given reference vector.

This method is useful but it is limited by a test capability that can only test VLSI circuits for which corresponding ESIM files exist.

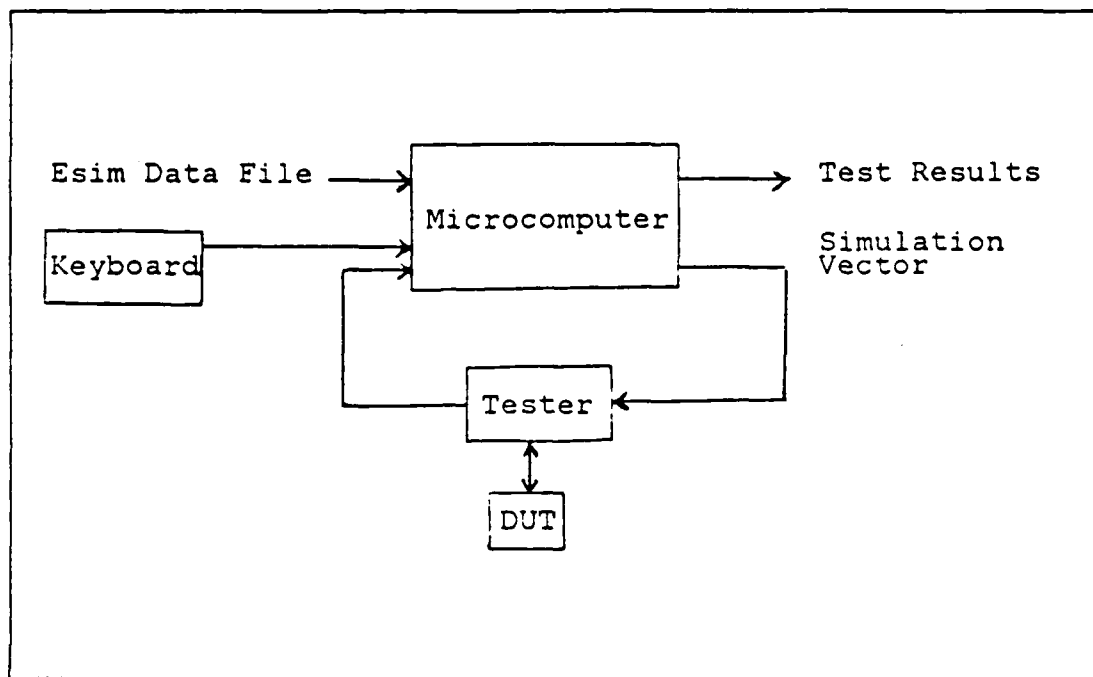


Figure 3.1 Automated Tester for VLSI.

#### D. BASIC CHARACTERISTICS OF A FUNCTIONAL TESTER

A typical test plan indicates five basic sequences of actions as below;

1. Generate the (next) test vector
2. Transmit the vector from tester to device under test.
3. Process the test vectors through the device under test.
4. Transmit the response from device under test to some response analysis circuit or tester.
5. Deduce the received response.

A sequence of these steps may be executed once for every test vector and every step is executed in one clock cycle. Keeping this basic plan in mind the most significant required characteristics of a tester are:

1. Sufficient test speed -- A test system with high speed memory buffering facilitates applying the test vectors to the device under test. A test system should also be capable of testing circuits at their original operating speed.
2. Sufficient number of I/O pins -- As an example the OM2 data path chip has 64 pins [Ref. 55]. Many of today's VLSI chips have more than 300 pins.
3. High speed memory buffering with sufficient depth. Today's CMOS memory RAMs have access times of about 55 nanoseconds. The depth must allow one to apply test vectors to the device under test without interruption caused by the need of memory reloading.
4. Accurate timing: The timing accuracy must satisfy a delay time of 500 ps or less. The master test clock generator circuit and other clock circuits in the tester should be designed to give this accuracy.
5. Ability to provide clocks to the device under test.
6. Ability to synchronize the device under test to the tester. This may be accomplished by designing as much as possible of the tester with custom VLSI circuits.
7. Avoid noise and skew problems which affect tester speed.
8. Expandability and flexibility. The tester can be easily reconfigured to improve its capabilities as well as to satisfy future requirements.

#### IV. FOCUS ON TWO BASIC APPROACHES

Having agreed on the functional test strategy which is the best for our environment under today's circumstances, we can start to examine two candidate approaches to design a functional test system. Chapters Two and Three provide the basic guidelines.

##### A. GENERAL PURPOSE MICROPROCESSOR AND BUS INTERFACE

###### 1. Objective

The purpose of this section is to examine the capabilities of a system shown in Figure 4.1 and to determine its hardware and interface requirements.

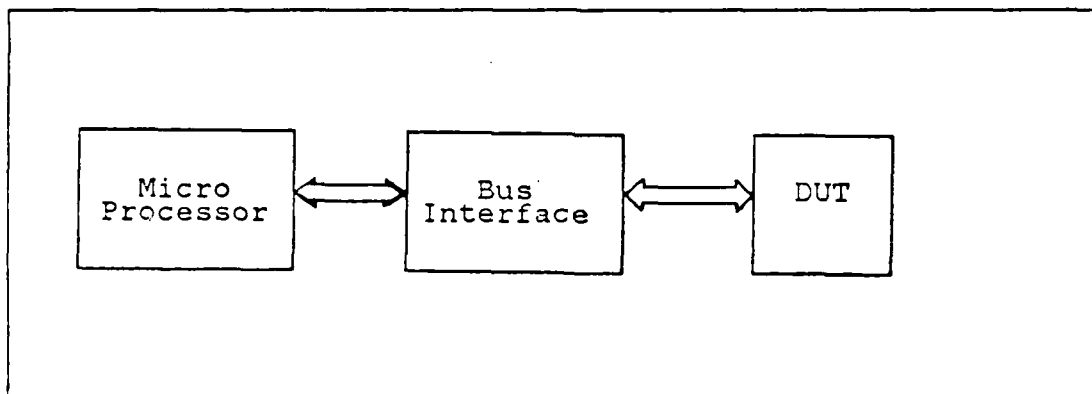


Figure 4.1 Microprocessor Based Test System.

###### 2. Discussion

The microprocessor controls the complete test process. The bus interface provides necessary connections between microprocessor and device under test. We have chosen two well known microprocessors for comparison. They are the Intel 8086 and the Motorola 68000. Table 3 lists



some of their features and the buses which support either or both of these microprocessors are listed in Table 4 .

TABLE 3  
SOME FEATURES OF 8086 AND 68000

	8086	68000
	----	-----
word size (data/instruction)	16/16	16/16
direct addressing range (words)	1 MBytes	16 MBytes
max clock freq. (MHz/phases)	5/1	8/1
on chip clock	yes	no
DMA capability	yes	yes
package size (pins)	40	64

The test system could operate as fast as the execution of memory fetch and output write followed by an input read and memory write. These steps take 40 clock periods for the 8086 and 40 clock periods in the absolute addressing mode for the 68000. For only 16-bit test vectors, a maximum test frequency of approximately 125 KHz for an Intel 8086 operating at 5 MHz is achievable. This translates to approximately 200 KHz for an Motorola 68000 operating at 8 MHz. Test vectors of 64-bits would require four of the previous cycles for each test cycle, indicating a maximum test frequency of approximately 30-50 KHz. These figures are dominant and no further calculation is necessary since the buses are not slower than these data transfer speeds. Some

other combinations could increase the speed but the result is still not a sufficient test speed.

TABLE 4  
TECHNICAL FACTORS FOR VARIOUS BUSES

	MULTIBUS -----	VME ---	S-100 -----
controlling body	IEEE 786	Motorola	IEEE-P961
VLSI support	Yes	Yes	
processors	8080, 8085 8086, 280 80186, 80188 80286, 28000 68000, 6800 6802, 6308 16032	68000 80186 16032	8080, 8085 8088, 280 80186, 80286 6800, 68000 16032
address width	24	16, 24, 32	16 or 24( expanded)
data width	8/16	8/16/32	8/16
bandwidth (MBytes/sec)	5/10	6/12/24	6/12
interrupt lines	8	7	100
interrupt ack	polled	daisy chain	polled
arbitration	serial or parallel	serial or parallel with daisy-chain	parallel

We have seen here that controlling the complete test by a microprocessor is not fast enough. As discussed before in Chapter Two, the way to increase test speed is to build a separate tester which has a controller and its own memory elements. At this point we will consider Katz's design frame which is proposed as a prototype testing facility in [Ref. 56].

### 3. Katz's Design Frame

When a fabricated chip is received, it is not easy to communicate with it. It must be supported for memory and communications. As stated in [Ref. 56], there is a need for standard design frames for which a user's circuit easily becomes a prototype system by inserting it into the frame. The design frame must provide system capabilities like memory, I/O ports, timers, standard bus, etc. This makes the testing and debugging of fabricated chips very easy and saves time.

Katz's design frame is based on the Intel iSBC 86/12A single board computer whose architecture is shown in Figure 4.2, [Ref. 57]. The standard board contains an 8086 microprocessor, 32K bytes of dynamic RAM, three programmable I/O ports, an RS-232 interface, programmable timers, an interrupt controller, provision for 16K bytes of ROM, and Multibus interface control logic [Ref. 57]. A feature of the iSBC 86/12A is that the memory is dual ported between microprocessor and the Multibus so that a master 8086 on one board can deposit and examine the memory contents on a slave board.

Katz's design frame is a cannibalized iSBC 86/12A board and a bus controller that emulates the 8086's own bus interface unit [Ref. 56]. The 8086 is simply removed and the user circuit/bus controller combination chip is plugged into the 8086 socket as shown in Figure 4.3 from [Ref. 56]. The bus controller acknowledges request signals and generates bus control signals that are identical to those of the 8086. The other subsystem on the board (I/O ports, memory chips, Multibus controller, etc.) behave as though they are interfaced with an 8086.

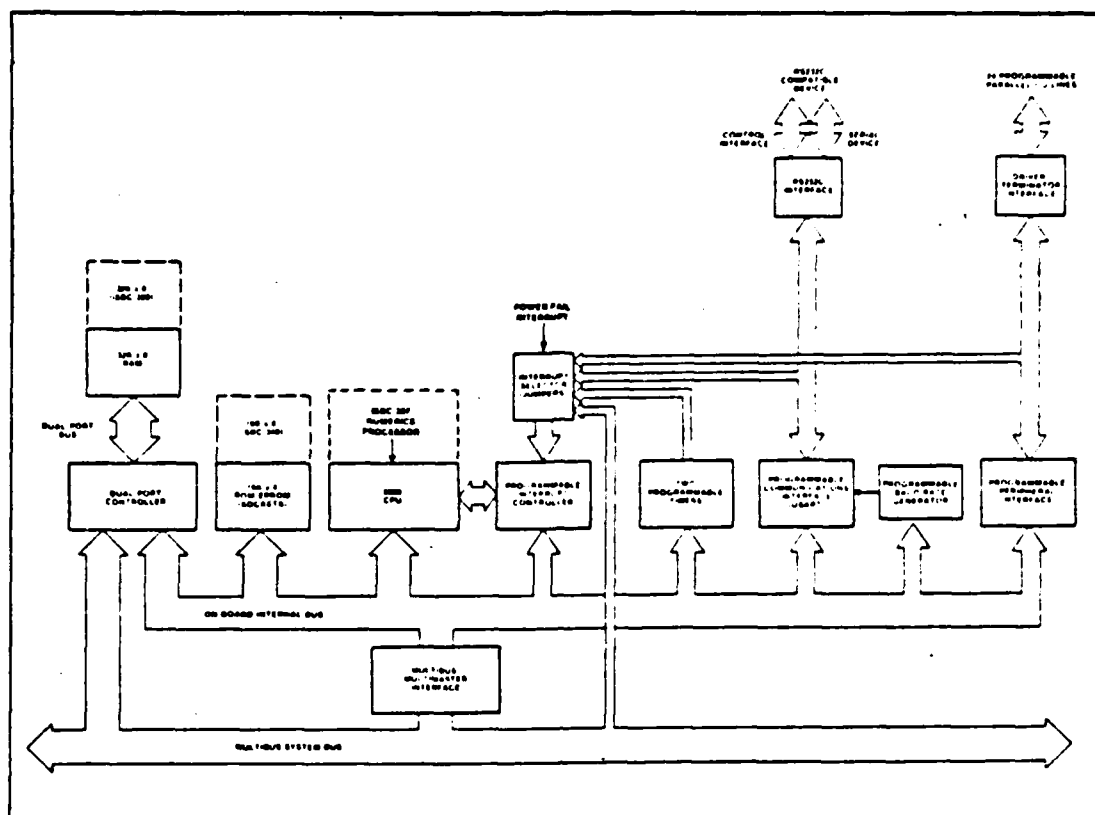


Figure 4.2 ISBC 86/12A Block Diagram.

As shown in Figure 4.4, a master slave configuration of two boards communicating through the Multibus seems promising as a test system. The master board can download data into the slave's memory and read data placed in the memory by the slave. This makes it possible to test fabricated chips.

#### 4. Results and Analysis

Using the design frame approach provides a tester with a maximum test speed of approximately 90 KHz. A 6-byte instruction queue provides pre-fetching and reduces the instruction cycle. This is why little improvement is observed in speed. Since the 8086 has 40 pins and the bus controller uses 12 of them, the tester would have 28 test

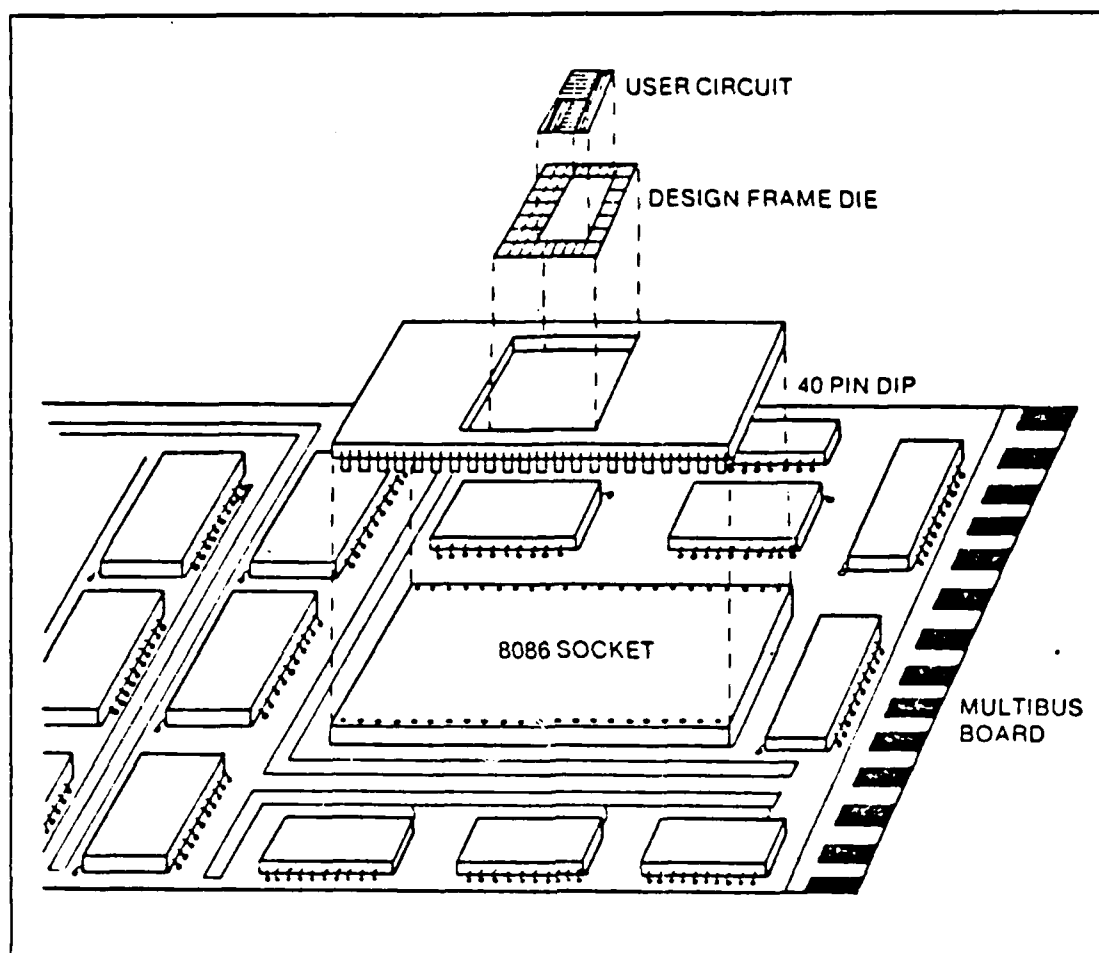


Figure 4.3 The Design Frame.

pins. The iSBC board has 32K x 8 bits RAM and it is also expandable to 64K bytes with the iSBC 300 32K bytes Multimodule RAM option. The power requirement is about 55 Watts. [Ref. 57]

The advantage of this approach is the capability of easily communicating externally through the Multibus. In this way the tester can be interfaced to a design station. But the test speed and the number of test pins on this tester are not sufficient.

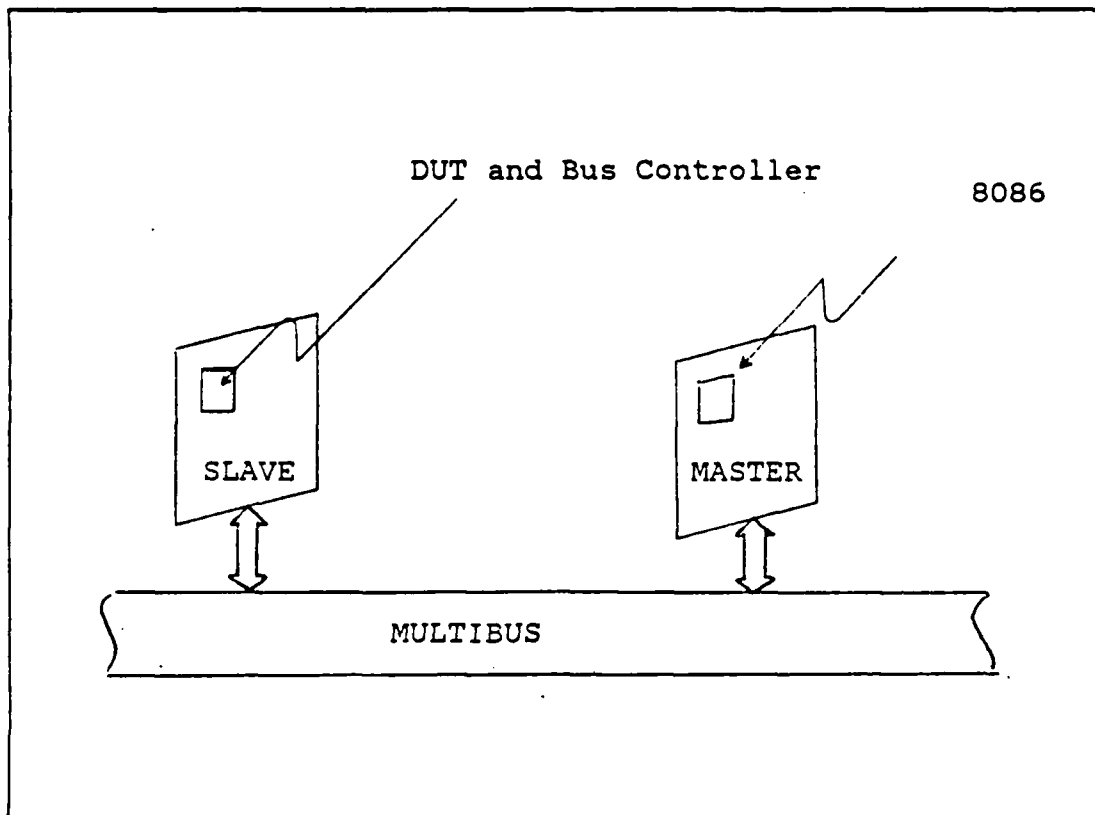


Figure 4.4 Master Slave Configuration.

#### B. A CUSTOM VLSI TEST CONTROLLER AND BUS INTERFACE

Let us now consider another approach. During a course on a VLSI design a simplified design of an integrated circuit tester was developed to reveal the advantages and disadvantages of this approach.

##### 1. Statement of Design Goal

The goal is to design an integrated circuit tester using nMOS technology by implementing the simplest testing approach: apply properly defined test or excitation vectors to the device under test and compare the outputs to a stored correct response. A simplified diagram of the tester is shown in Figure 4.5 All major components are available from Mathews and Newkirk's designer's library [Ref. 23].

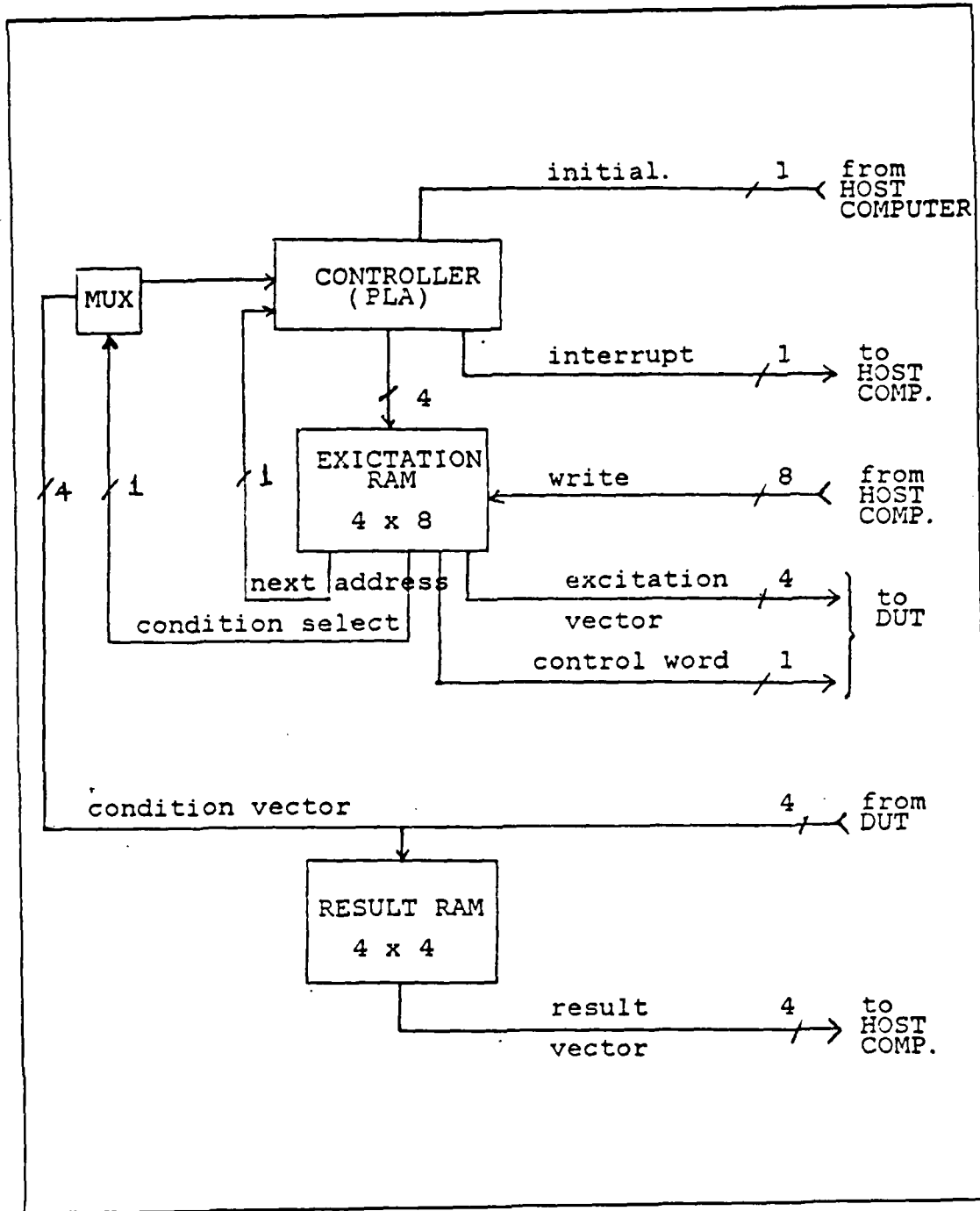


Figure 4.5 Functional Diagram of IC Tester.

## 2. Major Components

There are two basic components in this design; memory cells and a pla cell.

### Memory Cell :

The memory RAM is composed of three cells which are an Address cell, an InterfacePair cell and a RamPair cell ( Figure 4.6 ).

RamPair ( 28 x 33 )

Read from RamPair:  $B_{i0}$  has to be precharged and when the Readbar input is clocked the inverted value stored in ram cell appears on  $B_{i0}$ .

Write into it:  $B_{i0}$  is driven to the desired value and Writebar is clocked.

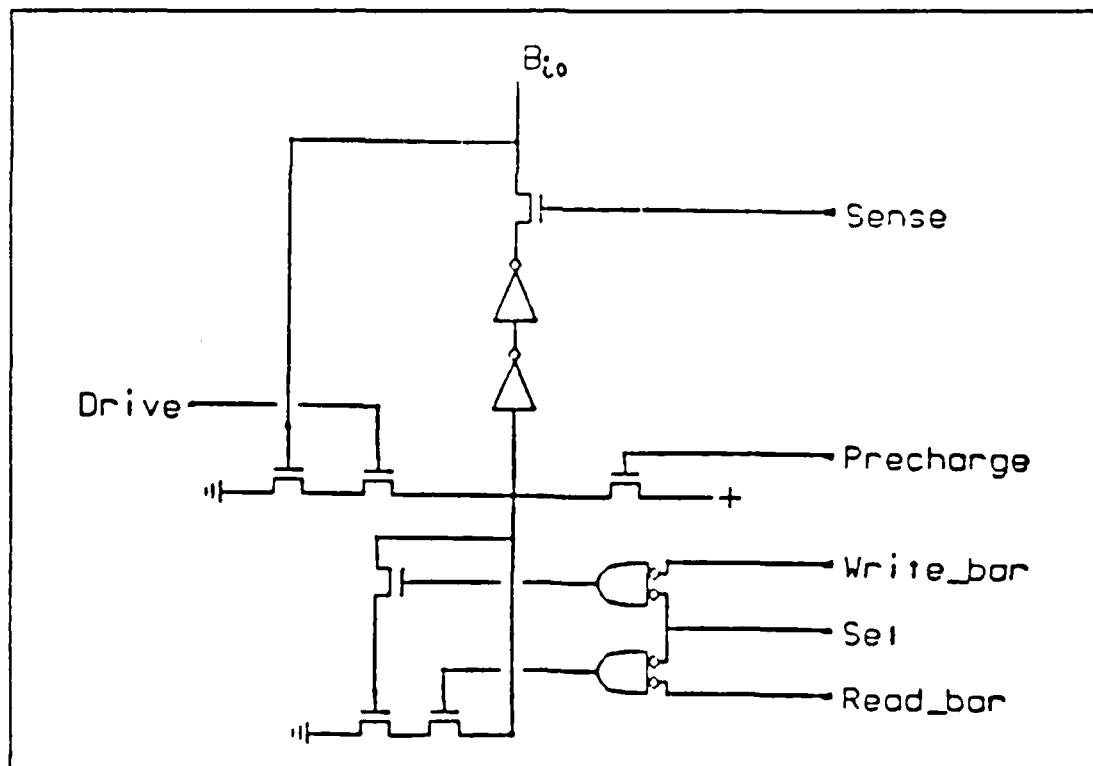


Figure 4.6 An Example Memory Subsystem.



InterfacePair ( 33 x 128 )

This cell provides the circuitry necessary for the outside world to access the ram cell. InterfacePair precharges  $B_{i0}$  during first clock phase. It reads out during the second clock phase when Sense is clocked and writes in during the second clock phase when Drive is clocked.

Address ( 24 x 137 )

This is a driver for the Read and Write control lines. Address qualifies the Readbar and Writebar clocks with the Selbar line and provides supperbuffered drive.

Pla Cell :

The pla cell is used to implement the controller, which is a simple sequencer in this case. All the inputs and outputs are clocked.

### 3. Structural Floor Plan

The cells used in this design are listed in Table 5 and the floor plan of the tester is shown in Figure 4.7. The system has a total of 32 interconnection pads. The boundary of the chip is 1186 by 1035. The pla controller and RAMs are placed in the middle. PadMux pads are used is to reduce the number of pads required. A PadMux cell acts like an input pad when its OUT/INbar input is low, and like an output pad when OUT/INbar is high. The final layout of the tester is shown in Figure 4.8 .

The power consumption of this design is estimated by power estimation program (Powerest). Its estimated average power is 99.36 mWatts and the maximum power is 178.98 mWatts.

### 4. Functional Specification

The host computer loads the desired 8 bit long vector into the excitation RAM. After this is done, the host

TABLE 5  
CELLS USED IN DESIGN OF TESTER

Name -----	Size -----	Amount -----	Cif No: -----
PadGnd	100 x 106	1	206
PadVdd	80 x 100	1	207
PadOut4	100 x 145	1	204
PadIn4	100 x 106	20	205
PadMux	100 x 180	9	282
RamPair	28 x 33	24	505
Interface	33 x 128	6	506
Address	24 x 137	8	503
InvSB4	20 x 42	1	234
Pla	148 x 79	1	501

computer initializes the controller. The excitation RAM supplies the next address and enables the controller to sequence through testing. A 4-bit vector is applied to the input of the device under test. A 4-bit result vector from the device under test is stored in the result RAM. Nand gates are used to implement the multiplexer. It is used to detect the case when all bits of the result vector are low. If the condition select bit is programmed to be high at any desired sequence of testing, this high signal enables the multiplexer. So whenever the result vector bits are all low after the multiplexer is enabled, the output of the multiplexer terminates the testing sequence. Either in this condition, or when the test sequence is completed, the controller interrupts the host computer. The host computer gets the result vectors from result RAM, analyzes the results and makes a decision about the device under test.

The only testing simulation done was the test of writing into and reading out of the RAMs. (Complete functional behavior of the tester depends on the interfaces with

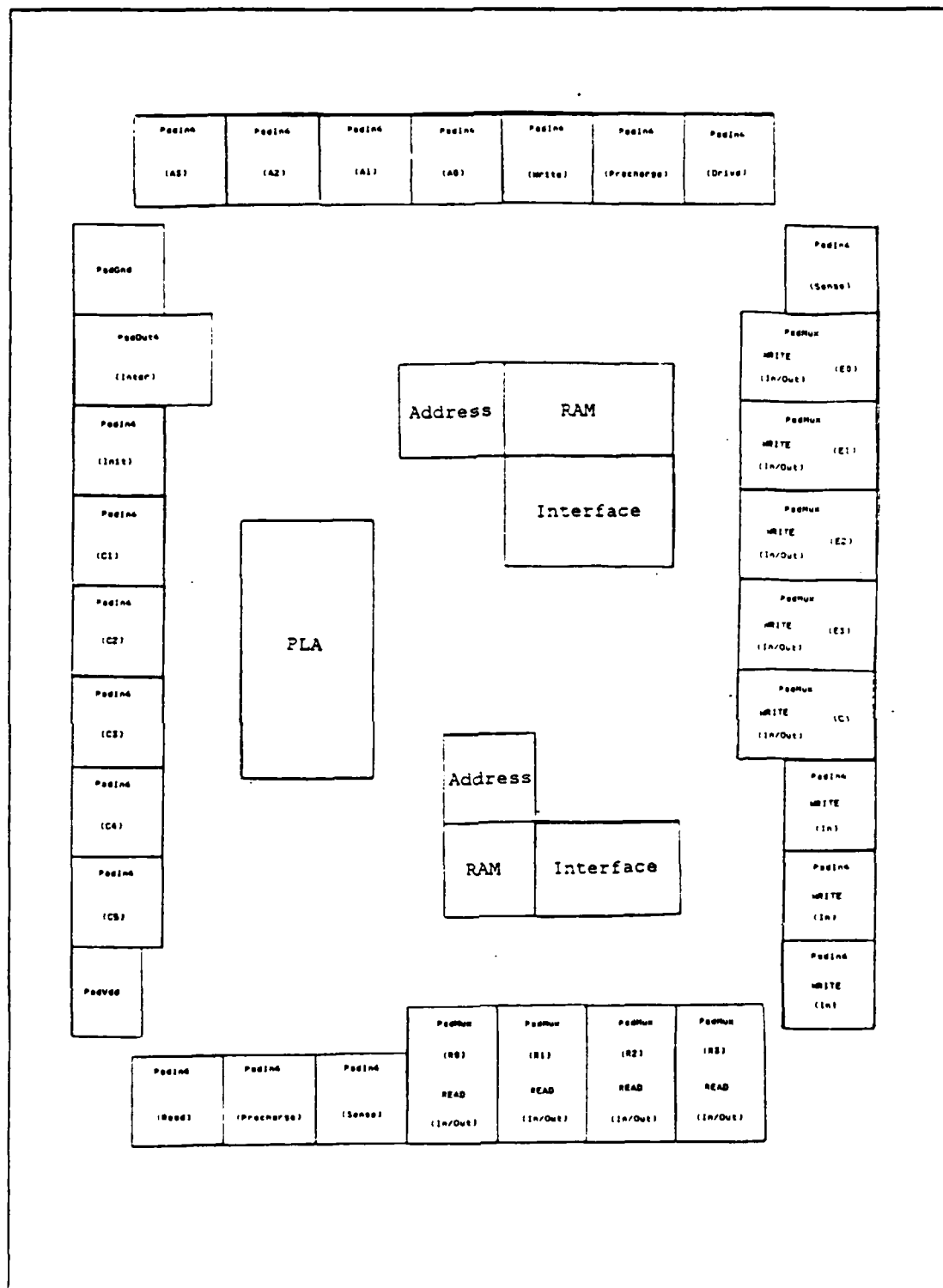


Figure 4.7 Floor Plan of Tester.

the host computer, and the device under test is very complicated to simulate). Simulation results, however, show that the RAMs are functioning correctly.

#### 5. Results and Further Directions

This tester has approximately 1 MHz test speed, 4 bits memory depth and 9 I/O pins. This methodology is effective but not practical from the application point of view. On the other hand, it can be easily expanded. The multiplexing idea can be extended to a desired complexity. The RAM dimensions can be increased to a desired size by iterating more memory cells.

However, we note that it is really not desirable to design a complete tester as a custom VLSI circuit. The tester circuit itself will be complex and hard to test. It also violates flexibility and expandability requirements. It is observed that a better way is to design a controller and other necessary internal interface circuits as a custom VLSI circuit. Separate high speed CMOS RAMs can be used as excitation and result memories. This increases flexibility and makes tester speed depend on basically the access time of the memory.

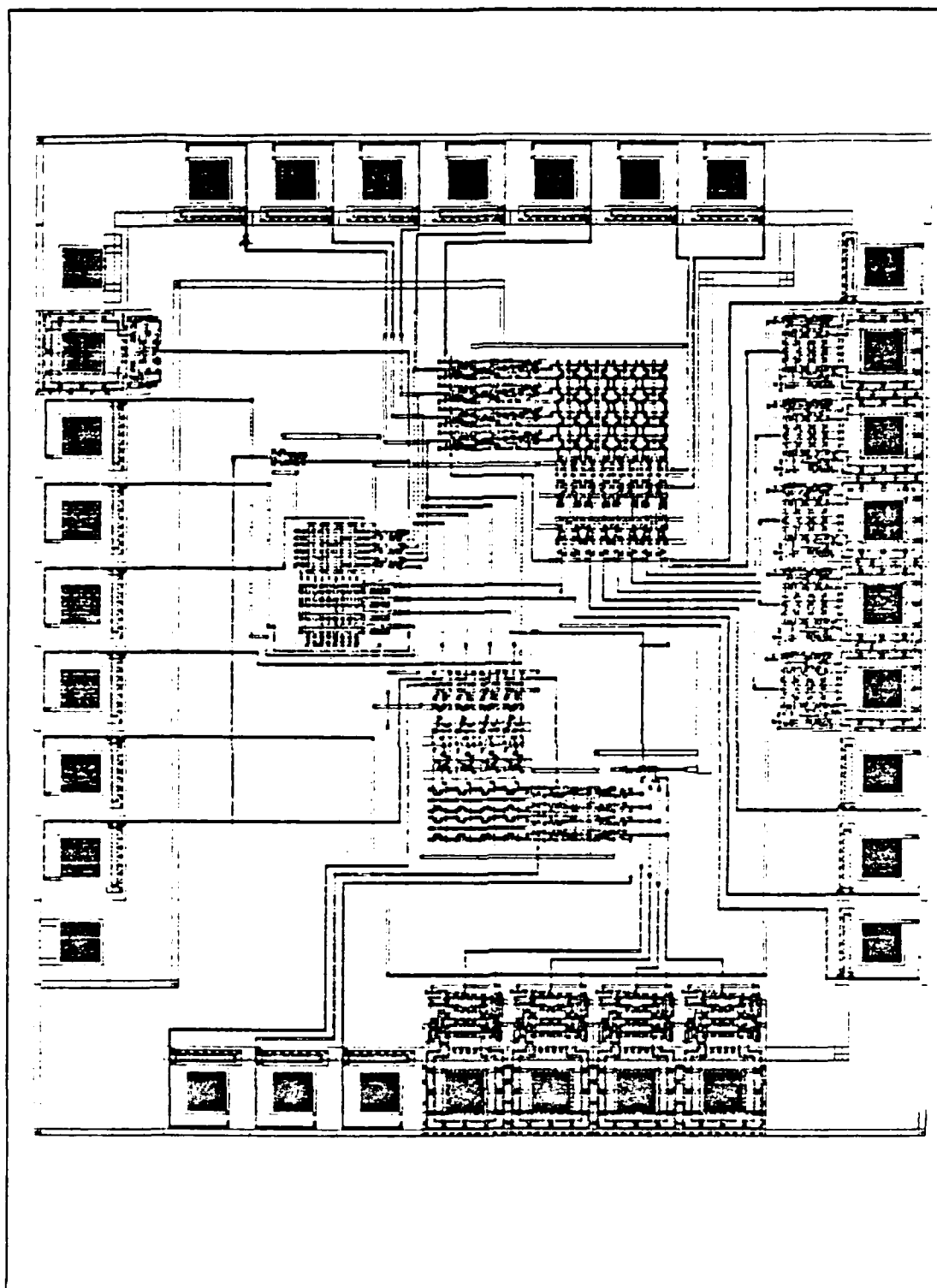


Figure 4.8 Final Layout of IC Tester.

## V. PROPOSED TEST SYSTEM ARCHITECTURE

So far two testing approaches have been examined and operating characteristics have been derived. A test system architecture will now be proposed to meet these guidelines. The logical structure of the controller and interface requirements between the tester and device under test will be examined. The speed, memory depth and the number of the I/O pins of the tester are basic considerations.

A system configuration of the proposed test system is presented in Figure 5.1 . A controller, memory board, programmable clocks, pipeline registers, and device under test board are parts of the tester. It is a combination of two basic approaches. The microcomputer can be a Z-100 or IBM PC and the microprocessor can be an Intel iSBC 86/12A single board computer. The microcomputer provides the opportunity for a high-level interface with the other portions of the tester and through the ethernet to other computer-aided design systems. This allows, for example, test programs to be written in high-level languages and a menu-driven user interface. This is the basic picture of the proposed test system architecture. First the functional tester of the system will be presented and then the presentation of the system will be completed with a scenario based on test consideration for the OM2 Data Path Chip designed at Caltech [Ref. 55] .

### A. HARDWARE DESIGN CONSIDERATIONS OF TESTER

A possible logical configuration of the functional tester is shown in Figure 5.2 . The tester can communicate with the microprocessor via the Multibus. The microprocessor

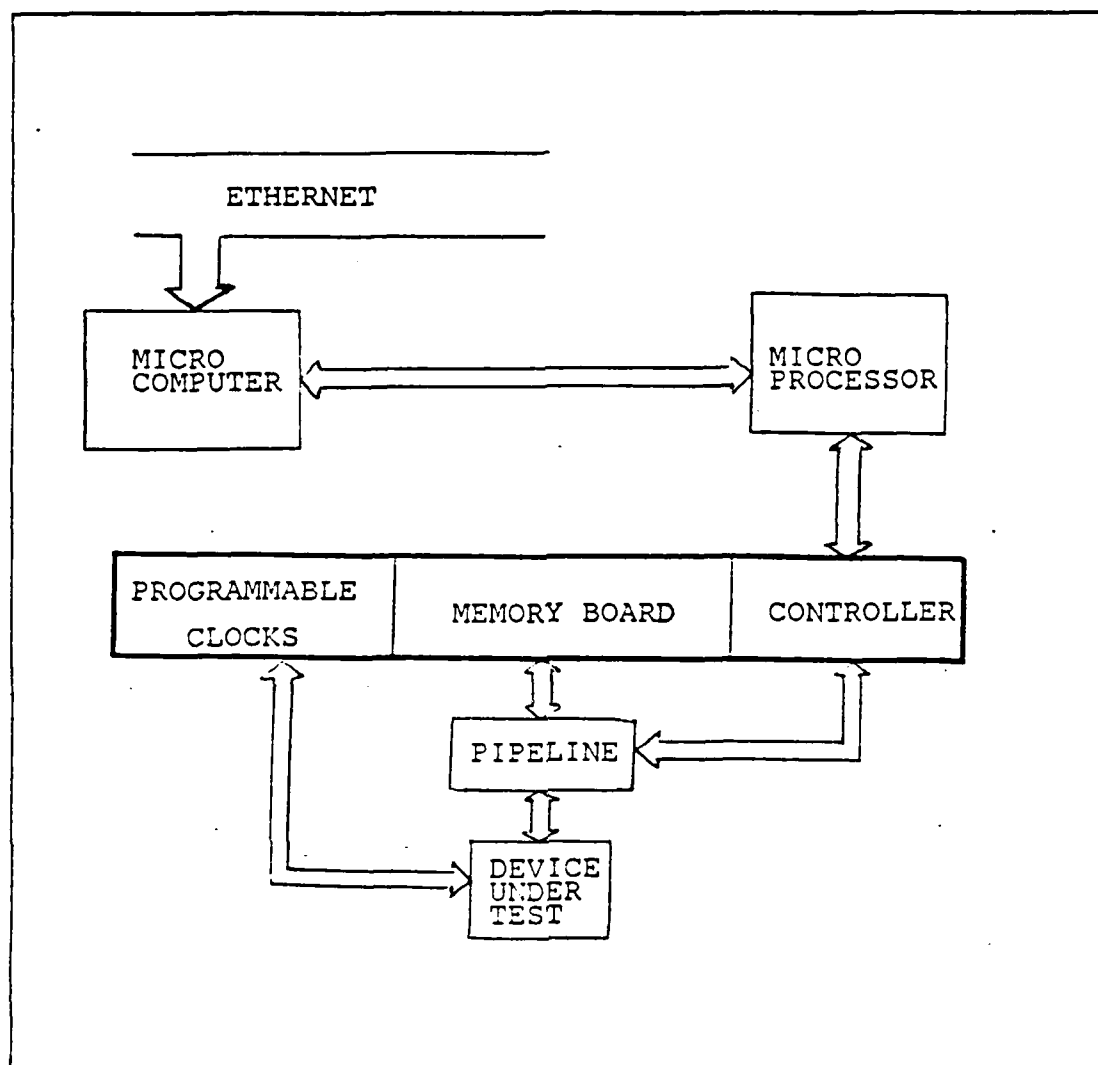


Figure 5.1 Proposed Test System.

downloads test vectors into the excitation RAM before the test phase. The test phase is considered as the process of applying test vectors and receiving response vectors without interruption. The microprocessor initializes the controller to start the test phase. Before getting into more detail let us examine the basic blocks.

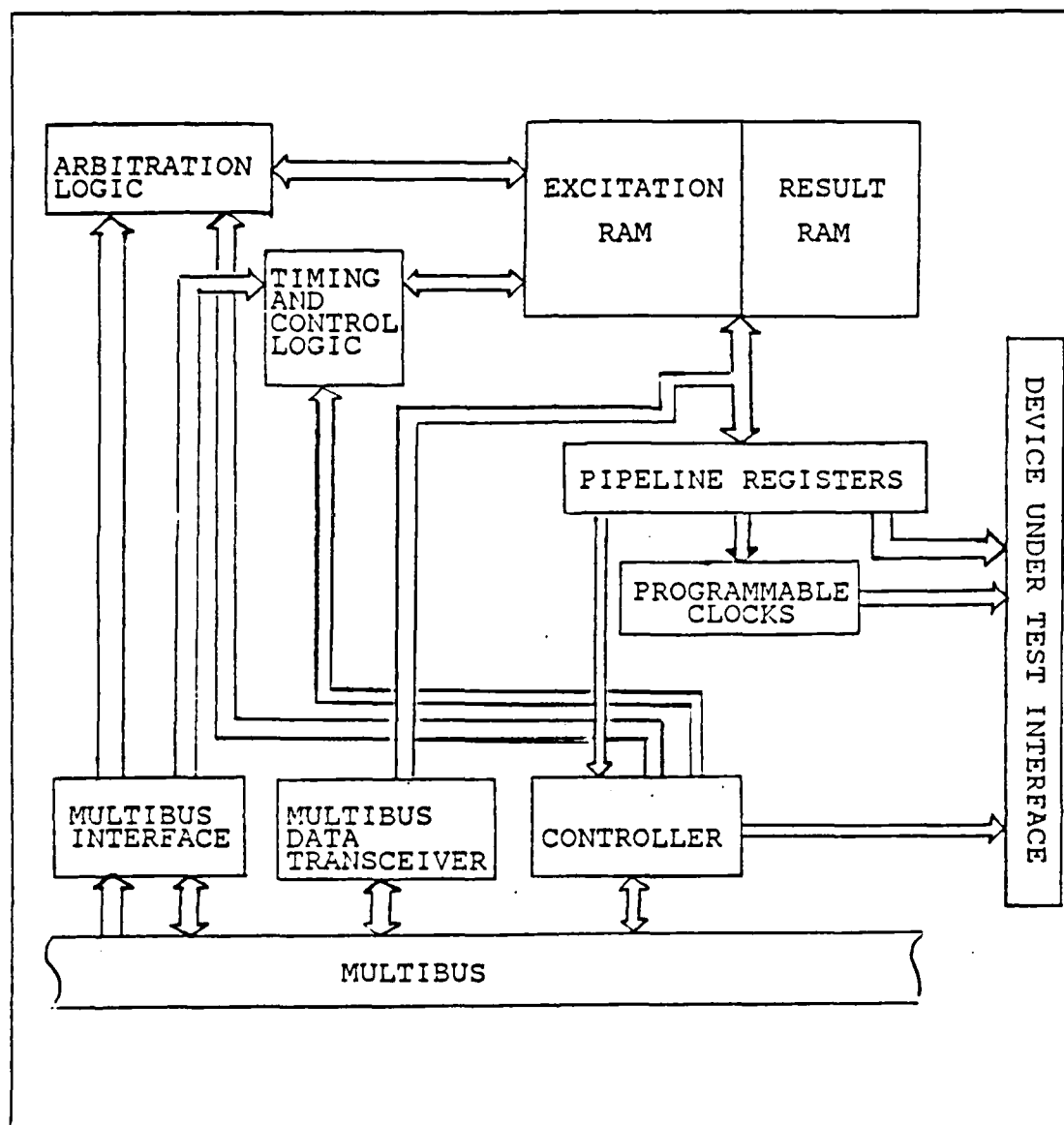


Figure 5.2 Configuration of Functional Tester.

### 1. Controller

The controller must provide at least three functions. First is the the generation of control signals for the timing and control logic circuit and the device under test interface circuit. The second function is address generation for the memory RAM. The third is generation of an



interrupt signal to the microprocessor when the test phase is completed.

The required control signals from the controller are addresses for the RAM, start test phase signal, interrupt signals to the microcomputer, the strobe signal to pipeline registers, RAM write and read signals, and so on. Complex address generation to provide branching and conditioning is not considered here. Simple address generation will be sufficient for our purposes. Since it is possible to create test vectors using high level language programs on a microcomputer, trying to make logical decisions based on some results during the test phase would only cause confusion and complexity. At least at the beginning, straightforward address generation is preferred. The controller can be designed as a PLA implementation of a finite state machine.

## 2. Memory Boards

Memory boards buffer the data vectors prior to transfer to and from the host computer and the device under test. As discussed before, there must be two different memory blocks. The first one is the excitation or test vector RAM and the other is the result RAM. Typical commercially available 2K x 8 bits CMOS random access memory elements have approximately 55 nanoseconds of read and write cycle time. As a first approximation, this means that an 18 MHz test speed is possible. During the test phase, the write signal to the excitation RAM and the read signal to the result RAM may be inhibited by control signals. This makes the excitation RAM a read only memory and the result RAM a write only memory during the test phase. So test vectors could be applied to the device under test and result vectors could be written into the result RAM without interruption.

To increase the depth, memory elements could be added in pairs and address lines could be increased, such as going from 2K x 8 bits to 4K x 8 bits. Increasing the width of the test vectors for example from 2K x 8 bits to 2K x 16 bits could be done by adding one more memory element.

### 3. Programmable Clocks

The programmable clocks board must supply necessary clock signals which are used by the tester and the device under test. Binary counters can be used to generate programmable clocks and an oscillator drives counters. For example, if two four-bit binary counters are cascaded, the resulting eight-bit counter would allow a count range of 0 - 255. A clock programmable in small increments, such as 10 nanoseconds or less, is desirable. An eight-bit counter with 10 nanosecond increments would permit programming of 0 - 2560 nanoseconds giving a range of about 400 KHz. The output of the counters would be compared to the output of storage elements (i.e. latches) by a comparator. These latches would be loaded with desired count values. When the comparator detects a match, a pulse is produced at the output of the comparator. This pulse toggles a flip flop and this produces a transition of the programmable clock.

In order to program a clock over the entire cycle at frequencies as low as 100 KHz, the programmable clock would require a count range of 0 - 1000 which means a 10 bit counter. The resolution considered here is 10 nanoseconds. To improve the resolution this time increment must be as small as possible. A VLSI circuit design can be considered, for example, which would use an internal clock of frequency 100 MHz or greater to produce a clock programmable in 10 nanoseconds or smaller increments.

#### 4. Interfaces

The first consideration here is the interface of device under test to the tester. Connecting test data lines coming from memory RAMs to device under test is possible by using pipeline registers. Typically, the set-up and propagation delay time of an SN74373 is approximately 15 nanoseconds. This is important because the speed of the tester is also dependent on this delay as well as memory access time and the address generation time for memory.

The device under test interface board should allow routing any of the data lines received from RAMs, programmable clock lines, Vdd, and GND to any pin of the device under test. The device under test interface and pipeline registers can be designed together as a custom VLSI circuit.

An arbitration logic circuit must simply allow the Multibus and the controller to share memory address lines and separate address lines from the Multibus interface circuit and connect them to the controller before a test phase is started.

The timing and control logic circuit must provide all signals necessary to control the dynamic RAM (i.e. read and write signals, etc.), a refresh timer and perhaps refresh counter. For instance, one of the functions of the Intel 8202 Dynamic RAM Controller is to provide these control signals [Ref. 58].

#### B. SUMMARY

The expected characteristics and capabilities of the proposed test system can be summarized as follows. The maximum possible test speed would be approximately 10 MHz. As stated before, approximately 55 nanosecond memory access time, approximately 15 nanosecond delay time of pipeline registers, and about 25 nanosecond address generation time

make the 10 MHz approximate test speed possible. Memory depth could be expanded up to 1M byte since 20 bit address lines are available. Up to 128 test pins could be provided. These figures are good enough for our purposes. For example, with such a tester it would be possible to test the 16 bit OM2 data path chip, [Ref. 55], which will be discussed next.

### C. DISCUSSION

Testing of the OM2 data path chip can be accomplished by this proposed test system. The OM2 16 bit data path chip contains 16 registers, an ALU, and a 16 bit shifter, and is designed as part of an LSI computer system, ( Figure 5.3 from [Ref. 55] ). The data path chip performs most of the data manipulation functions for the system. The operations are performed as directed by sequences of control microinstructions, which are fetched from a microcode memory using addresses generated by the controller chip.

The OM2 data path chip has two data ports for communication with the external system and a communication path to the controller chip. A block diagram of the OM2 data path chip is shown in Figure 5.4 from [Ref. 55]. The data ports are tristate with either internal or external control. Communication with the controller consists of a 16 bit literal port and a single flag bit. Seven control bits come directly from the microcode memory. [Ref. 55]

The data path chip has 64 pins, and runs on a single clock, generating  $\phi_1$  and  $\phi_2$  internally. When the clock is high, the internal buses transfer data. When the clock is low, the ALU is performing its operations. Microcode bits enter the data chip the phase before that code is to be executed. Therefore, the bus transfer code enters the data path chip when the clock is low, and the ALU code enters

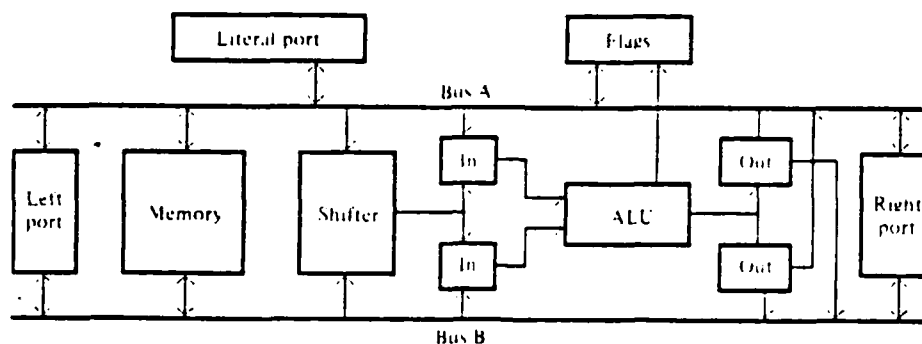


Figure 5.3 OM2 System Configuration.

when the clock is high. The minimum required total clock period is about 135 nanosecond. [Ref. 55]

Three programming examples are given and the program steps are listed in [Ref. 55]. The first is a 16 bit integer multiplication, second is parity generation, and the third shows how the data path can compute its own instruction. These programs would be used for functional test vector generation. Necessary high level and assembly language programs can be written to create a test vector data file, download it to the tester, perform testing, get the result data from the tester, and deduce the results.

The proposed functional tester could provide a 135 nanoseconds clock to the device under test and perform the testing of the OM2 data path chip.

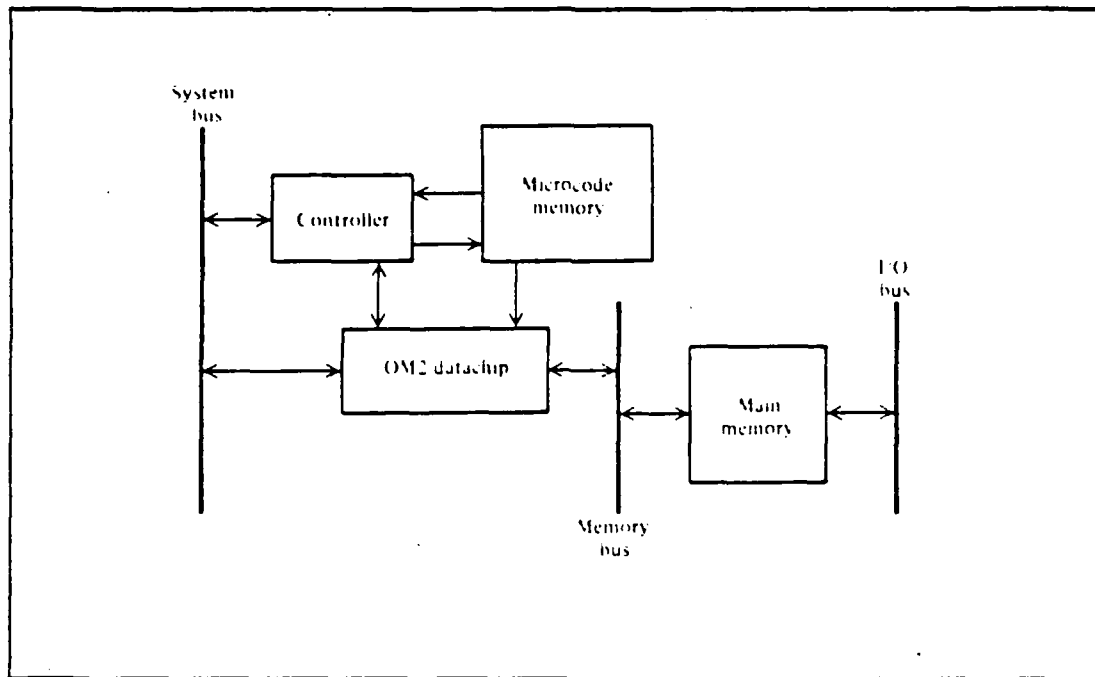


Figure 5.4 Block Diagram of The Data Path Chip.

## VI. CONCLUSION

Testing an integrated circuit chip is as important as designing it. If the designed chip is to be used in systems, it is essential to verify that it performs the intended function. This aspect must always be kept in mind during the design phase.

There have been a great number of studies on testing. In this thesis these methods were examined with consideration given to a university environment. It has been decided that a functional test strategy is the appropriate approach in an academic environment. The use of Esim files, which are generated during the design phase, as test and reference data vectors is recommended.

However, understanding other current methods is still necessary. For example, student designers should study Design For Testability methods and use them wherever appropriate. These methods not only reduce the effort of test generation and make automatic test generation possible, but also increase the observability and controllability of the chip. The LSSD (Level Sensitive Scan Design) method fits well with a two-phase clocking scheme and provides access to signals that normally are not visible without using a large number of extra pins.

After stating basic characteristics of a functional tester, two approaches were examined for designing a functional test system. It was observed in the first approach that controlling the complete test by a microprocessor is not fast enough. The second approach is faster and more reliable. Under the guidelines of this investigation, a test system architecture was proposed. Its 10 Mhz test speed, 1 Mbyte memory depth, 10 nanosecond clock generation accuracy and 128 test pins provide a feasible tester. These

characteristics are adequate for our purposes and allow, for example, a 16 bit LSI data path chip to be tested.



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